

LNP™ LUBRICOMP™ DFL32P compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DFL32P is a compound based on Polycarbonate resin containing 10% Glass Fiber, 15% PTFE. Added features of this material are: Wear Resistant, Exceptional Processing.

Also known as: LNP* LUBRICOMP* Compound DFL-4032 EP

Product reorder name: DFL32P

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Additive	PTFE Lubricant (15%)		
Features	Good Processability		
	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.30 to 0.50	%	
Across Flow : 24 hr	0.50 to 0.70	%	
Water Absorption			
24 hr, 50% RH	0.12	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.15	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4780	MPa	ASTM D638
--	4520	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	76.5	MPa	ASTM D638
Yield	77.0	MPa	ISO 527-2/5
Break ³	75.4	MPa	ASTM D638
Break	75.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.9	%	ASTM D638
Yield	3.0	%	ISO 527-2/5
Break ⁵	3.3	%	ASTM D638
Break	3.4	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	4240	MPa	ASTM D790

-- ⁷	4330	MPa	ISO 178
Flexural Stress			
--	123	MPa	ISO 178
Yield, 50.0 mm Span ⁸	128	MPa	ASTM D790
Break, 50.0 mm Span ⁹	128	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.43		
vs. Itself - Static	0.52		
Wear Factor			ASTM D3702 Modified
Ring	15.6	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	140	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	110	J/m	ASTM D256
23°C ¹⁰	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	610	J/m	ASTM D4812
23°C ¹¹	38	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	21.7	J	ASTM D3763
--	5.30	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	140	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	139	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	135	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	134	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	3.5E-5	cm/cm/°C	
Transverse : -30 to 30°C	7.5E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	293 to 304	°C	
Middle Temperature	310 to 321	°C	
Front Temperature	321 to 332	°C	
Processing (Melt) Temp	304 to 327	°C	
Mold Temperature	82.2 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			

1.	50 mm/min
2.	Type I, 5.0 mm/min
3.	Type I, 5.0 mm/min
4.	Type I, 5.0 mm/min
5.	Type I, 5.0 mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	1.3 mm/min
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	80*10*4 mm

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