

LNP™ LUBRICOMP™ DL003EXJ compound

Polycarbonate
SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DL003EXJ is a compound based on Polycarbonate containing 15% PTFE. Characteristics of this grade are Easy Molding, Low Extractable, Wear Resistant, Healthcare.

Also known as: LNP* LUBRICOMP* Compound DL-4030 EM LE HC

Product reorder name: DL003EXJ

General Information			
Additive	PTFE Lubricant (15%)		
Features	Good Moldability		
	Good Wear Resistance		
	Low Extractables		
	Lubricated		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.29	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.60 to 0.80	%	
Across Flow : 24 hr	0.70 to 0.90	%	
Water Absorption			
24 hr, 50% RH	0.10	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.15	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2090	MPa	ASTM D638
--	1980	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	46.0	MPa	ASTM D638
Yield	45.0	MPa	ISO 527-2/5
Break ³	38.0	MPa	ASTM D638
Break	34.8	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	5.6	%	ASTM D638
Yield	5.5	%	ISO 527-2/5
Break ⁵	17	%	ASTM D638
Break	22	%	ISO 527-2/5
Flexural Modulus			

50.0 mm Span ⁶	2190	MPa	ASTM D790
-- ⁷	2010	MPa	ISO 178
Flexural Stress	67.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.38		
vs. Itself - Static	0.23		
Wear Factor			ASTM D3702 Modified
Ring	0.250	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	15.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	180	J/m	ASTM D256
23°C ⁸	13	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1800	J/m	ASTM D4812
23°C ⁹	110	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	33.4	J	ASTM D3763
--	28.6	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	141	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	141	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	130	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	124	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	7.7E-5	cm/cm/°C	
Transverse : -30 to 30°C	7.7E-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	304 to 316	°C	
Front Temperature	310 to 321	°C	
Processing (Melt) Temp	299 to 316	°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.	80*10*4
9.	80*10*4
10.	80*10*4 mm
11.	80*10*4 mm

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