

LNP™ LUBRICOMP™ DL004 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DL004 is a compound based on Polycarbonate resin containing 20% PTFE. Added features of this material include: Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound DL-4040

Product reorder name: DL004

General Information			
UL YellowCard	E121562-101282870		
Additive	PTFE Lubricant (20%)		
Features	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.50 to 0.70	%	ASTM D955
Across Flow : 24 hr	0.60 to 0.80	%	ASTM D955
Across Flow : 24 hr	0.64	%	ISO 294-4
Flow : 24 hr	0.59	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.25	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.36	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2080	MPa	ASTM D638
--	2050	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	43.0	MPa	ASTM D638
Yield	44.0	MPa	ISO 527-2/5
Break ³	39.0	MPa	ASTM D638
Break	39.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	6.2	%	ASTM D638
Yield	5.9	%	ISO 527-2/5
Break ⁵	29	%	ASTM D638
Break	29	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	2060	MPa	ASTM D790

-- ⁷	1930	MPa	ISO 178
Flexural Strength			
--	73.8	MPa	ASTM D790
--	63.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.25		
vs. Itself - Static	0.21		
Wear Factor - Washer	7.50	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	110	J/m	ASTM D256
23°C ⁸	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1900	J/m	ASTM D4812
23°C ⁹	180	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	24.8	J	ASTM D3763
23°C, Total Energy	24.8	J	ASTM D3763
--	21.1	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	143	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	128	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	129	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	7.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.6E-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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

