

LNP™ LUBRICOMP™ DFL369XF compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LNP LUBRICOMP DFL369XF is a compound based on Polycarbonate resin containing Glass Fiber, PTFE, Flame Retardant. Added features of this material include: Internally Lubricated, Flame Retardant.

Also known as: LNP* LUBRICOMP* Compound DFL-4036 FR

Product reorder name: DFL369XF

General Information			
UL YellowCard	E207780-101284680		
Filler / Reinforcement	Glass Fiber		
Additive	PTFE Lubricant		
Features	Flame Retardant		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.10 to 0.30	%	ASTM D955
Across Flow : 24 hr	0.30 to 0.50	%	ASTM D955
Across Flow : 24 hr	0.40	%	ISO 294-4
Flow : 24 hr	0.21	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	10300	MPa	ASTM D638
--	9930	MPa	ISO 527-2/1
Tensile Strength			
Yield	117	MPa	ASTM D638
Yield	115	MPa	ISO 527-2
Break	112	MPa	ASTM D638
Break	115	MPa	ISO 527-2
Tensile Elongation			
Yield	2.2	%	ASTM D638, ISO 527-2
Break	2.3	%	ASTM D638
Break	2.2	%	ISO 527-2
Flexural Modulus			
--	8960	MPa	ASTM D790
--	9200	MPa	ISO 178
Flexural Strength			

--	179	MPa	ASTM D790
--	173	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.51		
vs. Itself - Static	0.52		
Wear Factor - Washer	28.3	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	660	J/m	ASTM D256
23°C ²	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	120	J/m	ASTM D4812
23°C ³	40	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	19.7	J	ASTM D3763
--	4.90	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	139	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	140	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	135	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	135	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	5.4E-5	cm/cm/°C	
Transverse : -40 to 40°C	2.2E-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.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		
5.	80*10*4 mm		

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