

LNP™ LUBRICOMP™ Lexan_LF1510A

compound

Polycarbonate
SABIC Innovative Plastics

Message:

LNP LUBRICOMP LEXAN_FL1510 compound is a 10% glass reinforced, 15% PTFE filled PC. Flame retardant and wear resistant. Tight tolerances.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Additive	PTFE lubricant (15%)		
Features	Good wear resistance		
	Lubrication		
	Flame retardancy		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	8.1	g/10 min	ASTM D1238
Molding Shrinkage			Internal method
Flow: 3.20mm	0.20 - 0.30	%	Internal method
Transverse flow: 3.20mm	0.35 - 0.50	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	72.4	MPa	ASTM D638
Fracture	72.4	MPa	ASTM D638
Tensile Elongation ²			ASTM D638
Yield	7.0	%	ASTM D638
Fracture	7.0	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	3790	MPa	ASTM D790
Flexural Strength ⁴ (Break, 50.0 mm Span)	117	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	100	J/m	ASTM D256
Unnotched Izod Impact (23°C)	510	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	16.9	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	133	°C	ASTM D648

1.8 MPa, unannealed, 3.20mm	127	°C	ASTM D648
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	3.6E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	5.4E-5	cm/cm/°C	ASTM E831
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI	80.0	°C	UL 746
Electrical	Nominal Value		Test Method
Comparative Tracking Index (CTI)	PLC 3		UL 746
High Amp Arc Ignition (HAI)	PLC 0		UL 746
Hot-wire Ignition (HWI)	PLC 0		UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	266 - 288	°C	
Middle Temperature	277 - 299	°C	
Front Temperature	288 - 310	°C	
Nozzle Temperature	282 - 304	°C	
Processing (Melt) Temp	288 - 310	°C	
Mold Temperature	71.1 - 93.3	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.025 - 0.076	mm	
NOTE			
1.	Type 1, 5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		

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