

LNP™ LUBRICOMP™ DX07404H compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRICOMP DX07404H is a compound based on Polycarbonate containing Proprietary Fillers. Added features of this grade are: Healthcare, Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound DX07404H

Product reorder name: DX07404H

General Information			
Filler / Reinforcement	Proprietary		
Features	Good Wear Resistance		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Molding Shrinkage			
Flow	0.40 to 0.60	%	Internal Method
Flow : 24 hr	0.50 to 0.70	%	ASTM D955
Across Flow	0.50 to 0.70	%	Internal Method
Across Flow : 24 hr	0.50 to 0.70	%	ASTM D955
Water Absorption			
24 hr, 50% RH	0.14	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.18	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2490	MPa	ASTM D638
--	2270	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	60.0	MPa	ASTM D638
Yield	59.0	MPa	ISO 527-2/5
Break ³	50.0	MPa	ASTM D638
Break	49.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	5.0	%	ASTM D638
Yield	5.0	%	ISO 527-2/5
Break ⁵	54	%	ASTM D638
Break	58	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	2380	MPa	ASTM D790
-- ⁷	2380	MPa	ISO 178

Flexural Stress			
--	81.0	MPa	ISO 178
Break, 50.0 mm Span ⁸	89.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	130	J/m	ASTM D256
23°C ⁹	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ¹⁰ (23°C)	180	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	135	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	135	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	124	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	125	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	6.4E-5	cm/cm/°C	
Transverse : -30 to 30°C	6.5E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Drying Time, Maximum	48	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.	5.0 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.	80*10*4		
10.	80*10*4		
11.	80*10*4 mm		
12.	80*10*4 mm		

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