

LNPTTM LUBRICOMPTM COMPOUND DBL34

DBL4034

DESCRIPTION

LNP LUBRICOMP DBL34 compound is based on Polycarbonate (PC) resin containing 20% glass bead and 15% PTFE. Added features of this grade include: Wear Resistant.

GENERAL INFORMATION	
Features	Wear resistant, Dimensional stability
Fillers	Glass Bead, PTFE
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component
Consumer	Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance
Electrical and Electronics	Mobile Phone - Computer - Tablets
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, yield, 5 mm/min	42	MPa	ISO 527
Tensile Stress, break, 5 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.1	%	ISO 527
Tensile Strain, break, 5 mm/min	4.6	%	ISO 527
Tensile Modulus, 1 mm/min	2800	MPa	ISO 527
Flexural Stress, break, 2 mm/min	76	MPa	ISO 178
Flexural Strain, break, 2 mm/min	5.3	%	ISO 178
Flexural Modulus, 2 mm/min	2900	MPa	ISO 178
IMPACT ⁽¹⁾			
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A
THERMAL ⁽¹⁾			
CTE, 23°C to 60°C, flow	6.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	6.9E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	137	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	130	°C	ISO 75/Af
PHYSICAL ⁽¹⁾			
Mold Shrinkage, flow ⁽²⁾	0.5 – 0.7	%	SABIC method
Wear Factor Washer	94	10 ⁻⁴ -10 in ⁵ -min/ft-lb-hr	ASTM D3702 Modified: Instr.
Dynamic COF	0.5	-	ASTM D3702 Modified: Instr.

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Static COF	0.7	-	ASTM D3702 Modified: Instr.
Density	1.45	g/cm ³	ISO 1183
Water Absorption, (23°C/24hrs)	0.13	%	ISO 62-1
INJECTION MOLDING ⁽³⁾			
Drying Temperature	120	°C	
Drying Time	4	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	305 – 325	°C	
Front - Zone 3 Temperature	320 – 330	°C	
Middle - Zone 2 Temperature	310 – 320	°C	
Rear - Zone 1 Temperature	295 – 305	°C	
Mold Temperature	80 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
- (3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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