

# LNPTM LUBRICOMPTM COMPOUND DFL349EF

DFL-4034 FR 94V-0

## DESCRIPTION

LNP LUBRICOMP DFL349EF compound is based on Polycarbonate (PC) resin containing 20% glass fiber, 15% PTFE. Added features of this grade include: Flame Retardant, Wear Resistant, Easy Molding.

GENERAL INFORMATION	
Features	Flame Retardant, Good Processability, Wear resistant
Fillers	Glass Fiber, 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
<b>MECHANICAL <sup>(1)</sup></b>			
Tensile Stress, break	88	MPa	ASTM D638
Tensile Strain, break	2.4	%	ASTM D638
Tensile Modulus, 50 mm/min	6520	MPa	ASTM D638
Flexural Stress	151	MPa	ASTM D790
Flexural Modulus	5870	MPa	ASTM D790
Tensile Stress, break	98	MPa	ISO 527
Tensile Strain, break	3.4	%	ISO 527
Tensile Modulus, 1 mm/min	7220	MPa	ISO 527
Flexural Stress	146	MPa	ISO 178
Flexural Modulus	5830	MPa	ISO 178
<b>IMPACT <sup>(1)</sup></b>			
Izod Impact, unnotched, 23°C	501	J/m	ASTM D4812
Izod Impact, notched, 23°C	106	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	15	J	ASTM D3763
Multiaxial Impact	12	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	40	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	11	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL <sup>(1)</sup></b>			
HDT, 1.82 MPa, 3.2mm, unannealed	137	°C	ASTM D648
CTE, -40°C to 40°C, flow	1.98E-05	1/°C	ASTM E831

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 40°C, xflow	6.12E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, flow	2.02E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.18E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	138	°C	ISO 75/Af
<b>PHYSICAL <sup>(1)</sup></b>			
Density	1.5	g/cm <sup>3</sup>	ASTM D792
Mold Shrinkage, flow, 24 hrs <sup>(2)</sup>	0.4 – 0.6	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs <sup>(2)</sup>	0.4 – 0.6	%	ASTM D955
Mold Shrinkage, flow, 24 hrs <sup>(2)</sup>	0.4 – 0.6	%	ISO 294
Mold Shrinkage, xflow, 24 hrs <sup>(2)</sup>	0.4 – 0.6	%	ISO 294
Wear Factor Washer	115	10 <sup>4</sup> -10 in <sup>4</sup> -min/ft-lb-hr	ASTM D3702 Modified: Manual
Dynamic COF	0.42	-	ASTM D3702 Modified: Manual
Static COF	0.34	-	ASTM D3702 Modified: Manual
Density	1.5	g/cm <sup>3</sup>	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.12	%	ISO 62
<b>FLAME CHARACTERISTICS <sup>(3)</sup></b>			
UL Yellow Card Link	<a href="#">E121562-101344536</a>	-	-
UL Yellow Card Link 2	<a href="#">E207780-101343859</a>	-	-
UL Recognized, 94V-0 Flame Class Rating	≥1.5	mm	UL 94
UL Recognized, 94V-1 Flame Class Rating	≥1.5	mm	UL 94
<b>INJECTION MOLDING <sup>(4)</sup></b>			
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) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.
- (4) 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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