LNP™ LUBRICOMP™ COMPOUND DX99699

DESCRIPTION

LNP LUBRICOMP DX99699 compound is based on Polycarbonate (PC) resin containing glass fiber and PTFE. Added features of this grade include: Wear Resistant, Mold Release

GENERAL INFORMATION	
Features	Wear resistant, Enhanced mold release
Fillers	Glass Fiber, PTFE
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Consumer	Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance
Electrical and Electronics	Electrical Devices and Displays, Electrical Components and Infrastructure

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, break	103	MPa	ASTM D638
Tensile Strain, break	3 – 4	%	ASTM D638
Flexural Stress	124	MPa	ASTM D790
Flexural Modulus	5170	MPa	ASTM D790
IMPACT [1]			
Izod Impact, unnotched, 23°C	420	J/m	ASTM D4812
Izod Impact, notched, 23°C	127	J/m	ASTM D256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed [1]	145	°C	ASTM D648
PHYSICAL [1]			
Specific Gravity	1.4	-	ASTM D792
Water Absorption, (23°C/24hrs)	0.08	%	ASTM D570
Mold Shrinkage, flow, 3.2 mm [2]	0.25 – 0.35	%	SABIC method
Matrix Tg	149	°C	DMA
Melt Volume Rate, MVR at 300°C/1.2 kg	10	cm³/10 min	ISO 1133
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	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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.

DISCLAIMER