LNP™ LUBRICOMP™ COMPOUND DFL32P

DFL-4032 EP
REGION AMERICAS

DESCRIPTION

LNP LUBRICOMP DFL32P compound is based on Polycarbonate (PC) resin containing 10% glass fiber, 15% PTFE. Added features of this grade include: Wear Resistant, Exceptional Processing.

GENERAL INFORMATION	
Features	High Flow, 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
MECHANICAL [1]			
Tensile Stress, yld, Type I, 5 mm/min	76	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	75	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	2.8	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	3.3	%	ASTM D638
Tensile Modulus, 50 mm/min	4780	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	128	MPa	ASTM D790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	128	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	4240	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	77	MPa	ISO 527
Tensile Stress, break, 5 mm/min	75	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.9	%	ISO 527
Tensile Strain, break, 5 mm/min	3.2	%	ISO 527
Tensile Modulus, 1 mm/min	4500	MPa	ISO 527
Flexural Stress	123	MPa	ISO 178
Flexural Modulus, 2 mm/min	4300	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched, 23°C	605	J/m	ASTM D4812
Izod Impact, notched, 23°C	110	J/m	ASTM D256
Multiaxial Impact	5	J	ISO 6603

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Instrumented Dart Impact Total Energy, 23°C	21	J	ASTM D3763
Izod Impact, unnotched 80*10*4 +23°C	35	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m²	ISO 180/1A
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	140	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	135	°C	ASTM D648
CTE, -30°C to 30°C, flow	3.5E-05	1/°C	ASTM D696
CTE, -30°C to 30°C, xflow	7.5E-05	1/°C	ASTM D696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	139	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	133	°C	ISO 75/Af
PHYSICAL [1]			
Density	1.36	g/cm³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.12	%	ASTM D570
Mold Shrinkage, flow, 24 hrs [2]	0.3 – 0.5	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs [2]	0.5 – 0.7	%	ASTM D955
Wear Factor Washer	139	10^-10 in^5-min/ft-lb-hr	ASTM D3702 Modified: Manual
Wear Factor Ring	15	10^-10 in^5-min/ft-lb-hr	ASTM D3702 Modified: Manual
Dynamic COF	0.42	-	ASTM D3702 Modified: Manual
Static COF	0.52	-	ASTM D3702 Modified: Manual
Density	1.36	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
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.

DISCLAIMER