

LNPT[™] LUBRICOMP[™] COMPOUND DX07404H

DX07404H

DESCRIPTION

LNP LUBRICOMP DX07404H compound is based on Polycarbonate (PC) resin containing proprietary lubricant. Added features of this grade include: Healthcare, Wear Resistant.

GENERAL INFORMATION	
Features	Wear resistant, Healthcare/Formula lock
Fillers	Unreinforced
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Hygiene and Healthcare	Pharmaceutical Packaging and Drug Delivery, Surgical devices, General Healthcare, Patient Testing
Packaging	Industrial Packaging

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, yld, Type I, 5 mm/min	60	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	50	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	5	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	54	%	ASTM D638
Tensile Modulus, 5 mm/min	2490	MPa	ASTM D638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	89	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2380	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	59	MPa	ISO 527
Tensile Stress, break, 5 mm/min	49	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5	%	ISO 527
Tensile Strain, break, 5 mm/min	58	%	ISO 527
Tensile Modulus, 1 mm/min	2270	MPa	ISO 527
Flexural Stress, break, 2 mm/min	81	MPa	ISO 178
Flexural Modulus, 2 mm/min	2380	MPa	ISO 178
IMPACT ⁽¹⁾			
Izod Impact, notched, 23°C	133	J/m	ASTM D256
Izod Impact, unnotched 80°10°4 +23°C	179	kJ/m ²	ISO 180/1U
Izod Impact, notched 80°10°4 +23°C	11	kJ/m ²	ISO 180/1A
THERMAL ⁽¹⁾			
HDT, 0.45 MPa, 3.2 mm, unannealed	135	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	124	°C	ASTM D648
CTE, -30°C to 30°C, flow	6.4E-05	1/°C	ASTM D696

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -30°C to 30°C, xflow	6.5E-05	1/°C	ASTM D696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	135	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	125	°C	ISO 75/Af
PHYSICAL ⁽¹⁾			
Density	1.25	g/cm ³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.14	%	ASTM D570
Mold Shrinkage, flow ⁽²⁾	0.4 – 0.6	%	SABIC method
Mold Shrinkage, xflow ⁽²⁾	0.5 – 0.7	%	SABIC method
Mold Shrinkage, flow, 24 hrs ⁽²⁾	0.5 – 0.7	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs ⁽²⁾	0.5 – 0.7	%	ASTM D955
Moisture Absorption (23°C / 50% RH)	0.18	%	ISO 62
INJECTION MOLDING ⁽³⁾			
Drying Temperature	120	°C	
Drying Time	2 – 4	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 300	°C	
Front - Zone 3 Temperature	280 – 300	°C	
Middle - Zone 2 Temperature	270 – 290	°C	
Rear - Zone 1 Temperature	260 – 280	°C	
Mold Temperature	80 – 110	°C	

- (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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