

LNP* Lubricomp* Compound DFL349EF

Americas: COMMERCIAL

Also known as: LNP* Lubricomp* Compound DFL-4034 FR 94V-0

Product reorder name: DFL349EF

LNP LUBRICOMP* DFL349EF is a compound based on Polycarbonate resin containing Flame Retardant, Glass Fiber, PTFE. Added features of this material include: Flame Retardant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	900	kgf/cm ²	ASTM D 638
Tensile Strain, break	2.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	66500	kgf/cm ²	ASTM D 638
Flexural Stress	1540	kgf/cm ²	ASTM D 790
Flexural Modulus	59900	kgf/cm ²	ASTM D 790
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
IMPACT			
Izod Impact, unnotched, 23°C	51	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	10	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	159	cm-kgf	ASTM D 3763
Multiaxial Impact	130	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	40	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	11	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	137	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.98E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.12E-05	1/°C	ASTM E 831
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



(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176.C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) 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.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	138	°C	ISO 75/Af
PHYSICAL			
Density	1.5	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.4 - 0.6	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.4 - 0.6	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.4 - 0.6	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.4 - 0.6	%	ISO 294
Wear Factor Washer	115	10 ⁻⁴ in ³ -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.42	-	ASTM D 3702 Modified
Static COF	0.34	-	ASTM D 3702 Modified
Density	1.5	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.12	%	ISO 62



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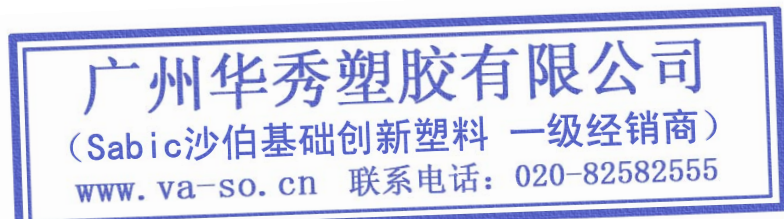
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	305 - 325	°C
Front - Zone 3 Temperature	320 - 330	°C
Middle - Zone 2 Temperature	310 - 320	°C
Rear - Zone 1 Temperature	295 - 305	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm



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