

LNP* Lubricomp* Compound DX09407H_2H5D249F

Americas: COMMERCIAL

Also known as: LNP* Lubricomp* Compound DX09407H

Product reorder name: DX09407H_2H5D249F

LNP* Lubricomp* DX09407H is a compound based on High Heat Polycarbonate containing proprietary fillers. Characteristics of this grade are: Internally Lubricated and Healthcare.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	650	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	540	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	6.8	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	68	%	ASTM D 638
Tensile Modulus, 5 mm/min	22700	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	910	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23500	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	64	MPa	ISO 527
Tensile Stress, break, 5 mm/min	56	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	6.9	%	ISO 527
Tensile Strain, break, 5 mm/min	111	%	ISO 527
Tensile Modulus, 1 mm/min	2130	MPa	ISO 527
Flexural Strain, break, 2 mm/min	76.8	%	ISO 178
Flexural Modulus, 2 mm/min	2080	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	225	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	14	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80°10*4 +23°C	191	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	139	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.43E+01	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.67E+01	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			
Coefficient of Linear Thermal Expansion	0	µm/Mk	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	137	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.5 - 0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.6 - 0.8	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.21	%	ISO 62

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	290 - 310	°C
Front - Zone 3 Temperature	295 - 315	°C
Middle - Zone 2 Temperature	280 - 305	°C
Rear - Zone 1 Temperature	270 - 295	°C
Mold Temperature	70 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

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