



LNP™ LUBRICOMP™ Compound DBL349E

Americas: COMMERCIAL

Also known as: LNP™ LUBRICOMP™ Compound DBL-4034 EM FR

Product reorder name: DBL349E

LNP™ LUBRICOMP™ DBL349E is a compound based on Polycarbonate resin containing 20% Glass Bead, 15% PTFE. Added features of this material include: Wear Resistant, Flame Retardant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	420	kgf/cm ²	ASTM D 638
Tensile Stress, break	380	kgf/cm ²	ASTM D 638
Tensile Strain, yield	2.9	%	ASTM D 638
Tensile Strain, break	9	%	ASTM D 638
Tensile Modulus, 50 mm/min	35100	kgf/cm ²	ASTM D 638
Flexural Modulus	28100	kgf/cm ²	ASTM D 790
Tensile Stress, yield	41	MPa	ISO 527
Tensile Stress, break	38	MPa	ISO 527
Tensile Strain, yield	2.8	%	ISO 527
Tensile Strain, break	7.6	%	ISO 527
Tensile Modulus, 1 mm/min	2970	MPa	ISO 527
Flexural Stress	78	MPa	ISO 178
Flexural Modulus	2900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	47	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	160	cm-kgf	ASTM D 3763
Multiaxial Impact	45	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	30	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	141	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	128	°C	ASTM D 648



LNP™ LUBRICOMP™ Compound DBL349E

Americas: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
CTE, -40°C to 40°C, flow	6.48E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.48E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.5E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.4E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	140	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	129	°C	ISO 75/Af
PHYSICAL			
Density	1.48	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)	0.6 - 0.8	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.54	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.69	%	ISO 294
Wear Factor Washer	90	10 ⁻⁴ -10 ⁻⁵ in ³ -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.51	-	ASTM D 3702 Modified
Static COF	0.7	-	ASTM D 3702 Modified
Density	1.48	g/cm ³	ISO 1183



LNP™ LUBRICOMP™ Compound DBL349E

Americas: COMMERCIAL

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