



LNP™ LUBRICOMP™ Compound DFL28

Americas: COMMERCIAL

Also known as: LNP™ LUBRICOMP™ Compound DFL-4028

Product reorder name: DFL28

LNP™ LUBRICOMP™ DFL28 is a compound based on Polycarbonate resin containing 40% Glass Fiber and 10% PTFE. Added feature of this material is: Wear Resistant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	1510	kgf/cm ²	ASTM D 638
Tensile Stress, break	1510	kgf/cm ²	ASTM D 638
Tensile Strain, yield	2.2	%	ASTM D 638
Tensile Strain, break	2.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	140600	kgf/cm ²	ASTM D 638
Flexural Stress	2100	kgf/cm ²	ASTM D 790
Flexural Modulus	119500	kgf/cm ²	ASTM D 790
Tensile Stress, yield	145	MPa	ISO 527
Tensile Stress, break	145	MPa	ISO 527
Tensile Strain, yield	2.1	%	ISO 527
Tensile Strain, break	2.1	%	ISO 527
Tensile Modulus, 1 mm/min	12930	MPa	ISO 527
Flexural Stress	216	MPa	ISO 178
Flexural Modulus	11800	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	90	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	16	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	231	cm-kgf	ASTM D 3763
Multiaxial Impact	59	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	57	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	16	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	145	°C	ASTM D 648



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	140	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.24E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	2.7E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	3.3E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	2.7E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	146	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	142	°C	ISO 75/Af
PHYSICAL			
Density	1.61	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.1 - 0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.4 - 0.6	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.21	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.51	%	ISO 294
Wear Factor Washer	129	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.52	-	ASTM D 3702 Modified
Static COF	0.52	-	ASTM D 3702 Modified
Density	1.61	g/cm ³	ISO 1183



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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