



LNP™ LUBRICOMP™ Compound DFL329

Americas: COMMERCIAL

Also known as: LNP™ LUBRICOMP™ Compound DFL-4032 FR

Product reorder name: DFL329

LNP LUBRICOMP™ DFL329 is a compound based on Polycarbonate resin containing 10% Glass Fiber, 15% PTFE. Added features of this material include: Flame Retardant, Internally Lubricated.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	770	kgf/cm ²	ASTM D 638
Tensile Strain, break	3	%	ASTM D 638
Tensile Modulus, 50 mm/min	44200	kgf/cm ²	ASTM D 638
Flexural Stress	1310	kgf/cm ²	ASTM D 790
Flexural Modulus	43500	kgf/cm ²	ASTM D 790
Tensile Stress, break	74	MPa	ISO 527
Tensile Strain, break	3	%	ISO 527
Tensile Modulus, 1 mm/min	4500	MPa	ISO 527
Flexural Stress	127	MPa	ISO 178
Flexural Modulus	4600	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	56	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	18	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	187	cm-kgf	ASTM D 3763
Multiaxial Impact	39	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	38	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	9	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	146	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	141	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.48E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.98E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	4.48E-05	1/°C	ISO 11359-2



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THERMAL			
CTE, -40°C to 40°C, xflow	4.99E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Af
PHYSICAL			
Density	1.4	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.12	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.5	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.33	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.49	%	ISO 294
Density	1.4	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
FLAME CHARACTERISTICS			
UL Compliant, 94V-0 Flame Class Rating (3)(4)	1.7	mm	UL 94 by SABIC-IP



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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