



LNP™ LUBRICOMP™ Compound DX09407H

Americas: COMMERCIAL

Also known as: LNP™ LUBRICOMP™ Compound DX09407H

Product reorder name: DX09407H

LNP LUBRICOMP DX09407H is a compound based on High Heat Polycarbonate containing proprietary fillers. Added features of this grade are: Wear Resistant, 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



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
CLTE, -30C to 100°C, flow	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