



LNP™ LUBRILOY™ Compound DF204

Americas: COMMERCIAL

Also known as: LNP™ LUBRILOY™ Compound DF-20

Product reorder name: DF204

LNP LUBRILOY DF204 is a compound based on Polycarbonate resin containing 20% Glass Fiber, Proprietary Lubricant. Added feature of th is grade is: Wear Resistant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1070	kgf/cm ²	ASTM D 638
Tensile Strain, break	2.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	68800	kgf/cm ²	ASTM D 638
Flexural Stress	1610	kgf/cm ²	ASTM D 790
Flexural Modulus	61100	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	77	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	18	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	142	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	137	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.38E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.84E-05	1/°C	ASTM E 831
Thermal Conductivity	0.25	W/m-°C	ASTM E 1530
PHYSICAL			
Density	1.32	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.2 - 0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.2 - 0.3	%	ASTM D 955
Wear Factor Washer	179	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.41	-	ASTM D 3702 Modified
Static COF	0.39	-	ASTM D 3702 Modified



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	100	°C
Drying Time	4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	305 - 315	°C
Front - Zone 3 Temperature	305 - 315	°C
Middle - Zone 2 Temperature	300 - 310	°C
Rear - Zone 1 Temperature	295 - 305	°C
Mold Temperature	65 - 95	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm