



LNP™ LUBRILOY™ Compound DX08333

Asia Pacific: COMMERCIAL

LNP LUBRILOY* DX08333 is an internally lubricated compound based on LEXAN Polycarbonate resin. Added features of this material include: ESD Safe, PTFE-free Wear & Friction solution and balanced mechanical performance

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	730	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.2	%	ASTM D 638
Tensile Modulus, 5 mm/min	74400	kgf/cm ²	ASTM D 638
Flexural Stress	1000	kgf/cm ²	ASTM D 790
Flexural Modulus	62200	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	113	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.2	%	ISO 527
Tensile Modulus, 1 mm/min	7310	MPa	ISO 527
Flexural Stress	113	MPa	ISO 178
Flexural Modulus, 2 mm/min	6760	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	30	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	173	cm-kgf	ASTM D 3763
Multiaxial Impact	101	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	22	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	138	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	132	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.9E-05	1/°C	ASTM E 831
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	140	°C	ISO 75/Bf



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	134	°C	ISO 75/Af
PHYSICAL			
Density	1.32	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow (5)	0.35	%	SABIC Method
Mold Shrinkage, xflow (5)	0.5	%	SABIC Method
Wear Factor Washer	80	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D 3702 Modified: Manual
ELECTRICAL			
Surface Resistivity	1.E+01 - 1.E+06	Ohm	ASTM D 257
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.8	mm	UL 94



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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