



LNP* Lubricomp* Compound DP003F

Asia Pacific: COMMERCIAL

Also known as: LNP* Lubricomp* Compound DL-4530 SM LEX

Product reorder name: DP003F

LNP LUBRICOMP* DP003F is a compound based on Polycarbonate resin containing Silicone, PTFE. Added features of this material include: Internally Lubricated.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yield	420	kgf/cm ²	ASTM D 638
Tensile Stress, break	490	kgf/cm ²	ASTM D 638
Tensile Strain, yield	5.4	%	ASTM D 638
Tensile Strain, break	15.3	%	ASTM D 638
Flexural Stress	770	kgf/cm ²	ASTM D 790
Flexural Modulus	21900	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	157	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	16	cm-kgf/cm	ASTM D 256
PHYSICAL			
Density	1.27	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.8	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.8	%	ASTM D 955



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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	300 - 315	°C
Front - Zone 3 Temperature	310 - 320	°C
Middle - Zone 2 Temperature	305 - 315	°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