

LNP* Lubriloy* Compound DF204

Americas: COMMERCIAL

Also known as: DF-20

Product Reorder Name: DF204

LNP* Lubriloy* DF204 is a compound based on Polycarbonate resin containing Glass Fiber, Proprietary Lubricant. Added features of this material include: Internally Lubricated.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, break	105	MPa	ASTM D 638
Tensile Strain, break	2.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	6750	MPa	ASTM D 638
Flexural Stress	158	MPa	ASTM D 790
Flexural Modulus	5990	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	758	J/m	ASTM D 4812
Izod Impact, notched, 23°C	181	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
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	Value	Unit	Standard
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	0.2 - 0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	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

Source GMD, last updated:09/24/2008

Processing

Parameter		
Injection Molding	Value	Unit
Drying Temperature	120	°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

Source GMD, last updated:09/24/2008

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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