

**Product Texts**

LNP LUBRILOY DF204 compound is based on Polycarbonate (PC) resin containing 20% glass fiber and a proprietary lubricant. Added features of this grade include: Wear Resistant.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.25	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.25	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Modulus	6750	MPa	ASTM D 638
Tensile Strength at Break	105	MPa	ASTM D 638
Elongation at Break	2.8	%	ASTM D 638
Flexural Modulus	5990	MPa	ASTM D 790
Flexural Strength	158	MPa	ASTM D 790
Izod Impact notched, 1/8 in	181	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	758	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
DTUL @ 66 psi	142	°C	ASTM D 648
DTUL @ 264 psi	137	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.1	%	ASTM D 570
Density	1320	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	290 - 315	°C	-
Mold temperature	65 - 95	°C	-
Zone 1	275 - 300	°C	-
Zone 2	280 - 300	°C	-
Zone 3	280 - 310	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.2 - 0.3	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific