

## LNP\* Lubricomp\* Compound DX07404H

Americas: COMMERCIAL

Wear resistant PC

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield	60	MPa	ISO 527
Tensile Stress, break	44	MPa	ISO 527
Tensile Strain, yield	5	%	ISO 527
Tensile Strain, break	14.1	%	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2510	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched 80*10*4 +23°C	179	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m <sup>2</sup>	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	123	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Density	1.25	g/cm <sup>3</sup>	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.23 - 0.43	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.35 - 0.55	%	ASTM D 955

Source GMD, last updated:09/09/2008

### Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	270 - 295	°C
Nozzle Temperature	265 - 290	°C
Front - Zone 3 Temperature	270 - 295	°C
Middle - Zone 2 Temperature	260 - 280	°C
Rear - Zone 1 Temperature	250 - 270	°C
Mold Temperature	70 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

Source GMD, last updated:09/09/2008

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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