

LNP™ THERMOCOMP™ DF006 compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LNP THERMOCOMP DF006 is a compound based on Polycarbonate resin containing 30% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound DF-1006

Product reorder name: DF006

General Information			
UL YellowCard	E121562-101282746	E121562-101344533	
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.45	g/cm ³	ASTM D792, ISO 1183
--	1.44	g/cm ³	ASTM D792
Water Absorption			
24 hr, 50% RH	0.070	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.070	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	8640	MPa	ASTM D638
Tensile Strength			
Fracture ²	114	MPa	ASTM D638
Fracture	114	MPa	ISO 527-2/5
Tensile Elongation			
Yield ³	2.7	%	ASTM D638
Fracture ⁴	3.2	%	ASTM D638
Fracture	7.5	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁵	8230	MPa	ASTM D790
-- ⁶	7870	MPa	ISO 178
Flexural Strength ⁷ (Break, 50.0 mm Span)	149	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	140	J/m	ASTM D256
23°C ⁸	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	910	J/m	ASTM D4812
23°C ⁹	57	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

0.45 MPa, unannealed, 3.20mm	144	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ¹⁰	145	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	140	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹¹	141	°C	ISO 75-2/Af

Injection	Nominal Value	Unit
Drying Temperature	121	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	293 - 304	°C
Middle Temperature	310 - 321	°C
Front Temperature	321 - 332	°C
Processing (Melt) Temp	304 - 327	°C
Mold Temperature	82.2 - 110	°C
Back Pressure	0.172 - 0.344	MPa
Screw Speed	30 - 60	rpm

NOTE	
1.	50 mm/min
2.	Type 1, 5.0 mm/min
3.	Type 1, 5.0 mm/min
4.	Type 1, 5.0 mm/min
5.	1.3 mm/min
6.	2.0 mm/min
7.	1.3 mm/min
8.	80*10*4
9.	80*10*4
10.	80*10*4 mm
11.	80*10*4 mm

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