

LNP™ THERMOCOMP™ NF004 compound

Polycarbonate + ABS

SABIC Innovative Plastics

Message:

LNP THERMOCOMP NF004 is a compound based on PC+ABS Blend resin containing Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound PCA-F-1004

Product reorder name: NF004

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	0.40	%	ASTM D955
Transverse flow: 24 hours	0.60	%	ASTM D955
Vertical flow direction: 24 hours	0.58	%	ISO 294-4
Flow direction: 24 hours	0.41	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6890	MPa	ASTM D638
--	6480	MPa	ISO 527-2/1
Tensile Strength			
Fracture	97.2	MPa	ASTM D638
Fracture	95.0	MPa	ISO 527-2
Tensile Elongation			
Fracture	2.5	%	ASTM D638
Fracture	2.6	%	ISO 527-2
Flexural Modulus			
--	6210	MPa	ASTM D790
--	6000	MPa	ISO 178
Flexural Strength			
--	138	MPa	ASTM D790
--	143	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	120	J/m	ASTM D256
23°C ²	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	600	J/m	ASTM D4812

23°C ³	37	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	18.2	J	ASTM D3763
--	5.20	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	139	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁴	140	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	135	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁵	134	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	7.7E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	3.2E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	232 - 243	°C	
Middle Temperature	249 - 260	°C	
Front Temperature	260 - 271	°C	
Processing (Melt) Temp	249 - 271	°C	
Mold Temperature	37.8 - 82.2	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		
5.	80*10*4 mm		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 1342475533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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