

LNP™ THERMOCOMP™ NF004 compound

Polycarbonate + ABS

SABIC Innovative Plastics

Message:

LNP THERMOCOMP NF004 is a compound based on PC+ABS resin containing 20% Glass Fiber.

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

Product reorder name: NF004

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
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 hr	0.40	%	ASTM D955
Across Flow : 24 hr	0.60	%	ASTM D955
Across Flow : 24 hr	0.58	%	ISO 294-4
Flow : 24 hr	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			
Break	97.2	MPa	ASTM D638
Break	95.0	MPa	ISO 527-2
Tensile Elongation			
Break	2.5	%	ASTM D638
Break	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, 3.20 mm	139	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	140	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	135	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	134	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	7.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	3.2E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	232 to 243	°C	
Middle Temperature	249 to 260	°C	
Front Temperature	260 to 271	°C	
Processing (Melt) Temp	249 to 271	°C	
Mold Temperature	37.8 to 82.2	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 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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