

LNP™ COLORCOMP™ D1000FL compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP COLORCOMP D1000FL is an unfilled compound based on Polycarbonate resin. Added features of this grade are: Superior Molding, Low Extractible.

Also known as: LNP* COLORCOMP* Compound D-1000 LE SM

Product reorder name: D1000FL

General Information			
UL YellowCard	E121562-101283791		
Features	Good Moldability		
	Low Extractables		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Water Absorption (24 hr, 50% RH)	0.30	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2390	MPa	ASTM D638
Tensile Strength ² (Yield)	64.0	MPa	ASTM D638
Tensile Elongation ³ (Yield)	6.0	%	ASTM D638
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	137	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	125	°C	ISO 75-2/Af
Thermal Conductivity	0.17	W/m/K	ASTM E1530
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	293 to 304	°C	
Middle Temperature	310 to 321	°C	
Front Temperature	321 to 332	°C	
Processing (Melt) Temp	304 to 327	°C	
Mold Temperature	82.2 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		

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