

LNP™ THERMOCOMP™ DF0081PI compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LNP THERMOCOMP DF0081PI is a compound based on Polycarbonate resin containing Glass Fiber, Flame Retardant. Added features of this material include: High Modulus, good flatness, Non-Brominated & Non-Chlorinated Flame Retardant.

General Information			
UL YellowCard	E207780-101343768		
Filler / Reinforcement	Glass Fiber		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.54	g/cm³	ASTM D792
Molding Shrinkage			Internal Method
Flow	0.40	%	
Across Flow	0.41	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	12700	MPa	ASTM D638
--	12500	MPa	ISO 527-2/1
Tensile Strength			
Break ²	130	MPa	ASTM D638
Break	123	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	1.8	%	ASTM D638
Break	1.7	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	10000	MPa	ASTM D790
-- ⁵	10800	MPa	ISO 178
Flexural Strength ⁶ (Break, 50.0 mm Span)	170	MPa	ASTM D790
Flexural Strain at Break ⁷	1.9	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	81	J/m	ASTM D256
23°C ⁸	9.0	kJ/m²	ISO 180/1A
Unnotched Izod Impact			

23°C	260	J/m	ASTM D4812
23°C ⁹	22	kJ/m ²	ISO 180/1U
Instrumented Dart Impact (23°C, Energy at Peak Load)	10.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	110	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	102	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	3.0 to 6.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	260 to 280	°C	
Middle Temperature	270 to 290	°C	
Front Temperature	280 to 300	°C	
Nozzle Temperature	285 to 305	°C	
Processing (Melt) Temp	285 to 310	°C	
Mold Temperature	80.0 to 110	°C	
Back Pressure	0.100 to 0.300	MPa	
Screw Speed	50 to 90	rpm	
NOTE			
1.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	2 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		

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