

LNP™ THERMOCOMP™ DF006P compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* DF006P is a compound based on Polycarbonate resin containing 30% Glass Fiber. Added features of this material include:
Exceptional Processing.

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

Product reorder name: DF006P

General Information			
UL YellowCard	E121562-101284106		
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Good Processability		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.15	%	ASTM D955
Across Flow : 24 hr	0.67	%	ASTM D955
Across Flow : 24 hr	0.51	%	ISO 294-4
Flow : 24 hr	0.090	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	10500	MPa	ASTM D638
--	10000	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	125	MPa	ASTM D638
Yield	125	MPa	ISO 527-2/5
Break ³	125	MPa	ASTM D638
Break	125	MPa	ISO 527-2/5
Tensile Elongation ⁴			ASTM D638
Yield	2.4	%	
Break	2.4	%	
Flexural Modulus ⁵ (50.0 mm Span)	8730	MPa	ASTM D790
Flexural Strength ⁶			ASTM D790
Yield, 50.0 mm Span	165	MPa	
Break, 50.0 mm Span	165	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	110	J/m	ASTM D256

23°C ⁷	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	770	J/m	ASTM D4812
23°C ⁸	48	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	13.0	J	ASTM D3763
--	2.18	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	134	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	131	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁹	134	°C	ISO 75-2/Af
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm, Testing by SABIC	V-2		
3.00 mm, Testing by SABIC	V-0		
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		
4.	Type I, 5.0 mm/min		
5.	1.3 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		

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