

LNP™ THERMOCOMP™ DC006ER compound

Polycarbonate
SABIC Innovative Plastics

Message:

LNP THERMOCOMP* DC006ER is a compound based on Polycarbonate resin containing 30% Carbon Fiber. Added features of this material include: Easy Molding, Mold Release, Electrically Conductive.
Also known as: LNP* THERMOCOMP* Compound DC-1006 EM MR
Product reorder name: DC006ER

General Information			
Filler / Reinforcement	Carbon Fiber,30% Filler by Weight		
Additive	Mold Release		
Features	Electrically Conductive		
	Good Mold Release		
	Good Moldability		
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	0.040 to 0.10	%	ASTM D955
Across Flow : 24 hr	0.30 to 0.40	%	ASTM D955
Across Flow : 24 hr	0.35 to 0.40	%	ISO 294-4
Flow : 24 hr	0.040 to 0.13	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.14	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.21	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	19600	MPa	ASTM D638
--	16700	MPa	ISO 527-2/1
Tensile Strength			
Break	151	MPa	ASTM D638
Break	149	MPa	ISO 527-2
Tensile Elongation			
Break	1.9	%	ASTM D638
Break	1.8	%	ISO 527-2
Flexural Modulus			
--	14500	MPa	ASTM D790
--	16500	MPa	ISO 178
Flexural Strength			

--	221	MPa	ASTM D790
--	226	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	69	J/m	ASTM D256
23°C ²	7.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	480	J/m	ASTM D4812
23°C ³	32	kJ/m ²	ISO 180/1U
Instrumented Dart Impact (23°C, Energy at Peak Load)	9.60	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	144	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	141	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	140	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	2.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	2.8E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2 to 1.0E+6	ohms	ASTM D257
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.	80*10*4		
3.	80*10*4		
4.	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 13424755533

Email: sales@su-jiao.com

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

