

LNP™ THERMOCOMP™ DF004P compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DF004P is a Polycarbonate base resin containing Glass Fiber. Characteristics of this grade are Exceptional Processing.

Also known as: LNP* THERMOCOMP* Compound DF-1004 EP BK8-115

Product reorder name: DF004P

General Information			
UL YellowCard	E207780-101358156		
Filler / Reinforcement	Glass fiber reinforced material		
Features	Workability, good		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.10 - 0.30	%	ASTM D955
Transverse flow: 24 hours	0.30 - 0.50	%	ASTM D955
Water Absorption			
24 hr, 50% RH	0.050	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.050	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	10900	MPa	ASTM D638
--	6340	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	43.0	MPa	ASTM D638
Yield	28.0	MPa	ISO 527-2/5
Fracture ³	106	MPa	ASTM D638
Fracture	102	MPa	ISO 527-2/5
Tensile Elongation			
Fracture ⁴	1.6	%	ASTM D638
Fracture	2.7	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁵	6400	MPa	ASTM D790
-- ⁶	12500	MPa	ISO 178
Flexural Stress			
--	202	MPa	ISO 178
Fracture, 50.0mm span ⁷	156	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	91	J/m	ASTM D256
23°C ⁸	7.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	740	J/m	ASTM D4812
23°C ⁹	45	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	138	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ¹⁰	138	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	95.0	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹¹	97.0	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	293 - 304	°C	
Middle Temperature	310 - 321	°C	
Front Temperature	321 - 332	°C	
Processing (Melt) Temp	304 - 327	°C	
Mold Temperature	82.2 - 110	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	Type 1, 5.0 mm/min		
5.	1.3 mm/min		
6.	2.0 mm/min		
7.	1.3 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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