

LNP™ THERMOCOMP™ DF004 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DF004 is a compound based on Polycarbonate resin containing 20% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound DF-1004

Product reorder name: DF004

General Information			
UL YellowCard	E121562-101282746	E121562-101344533	
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.20	%	ASTM D955, ISO 294-4
Across Flow : 24 hr	0.50	%	ASTM D955
Across Flow : 24 hr	0.45	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5520	MPa	ASTM D638
--	5940	MPa	ISO 527-2/1
Tensile Strength ² (Break)	91.7	MPa	ASTM D638
Tensile Elongation ³ (Break)	9.5	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	5520	MPa	ASTM D790
Flexural Strength ⁵ (Break, 50.0 mm Span)	148	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	130	J/m	ASTM D256
23°C ⁶	8.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	960	J/m	ASTM D4812
23°C ⁷	59	kJ/m ²	ISO 180/1U
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	139	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁸	141	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	Test Method
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. 1.3 mm/min
5. 1.3 mm/min
6. 80*10*4
7. 80*10*4
8. 80*10*4 mm

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