

LNP™ THERMOCOMP™ NF002 compound

Polycarbonate + ABS

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* NF002 is a compound based on PC+ABS resin containing 10% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound PCA-F-1002

Product reorder name: NF002

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.23	g/cm ³	ASTM D792, ISO 1183
--	1.22	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.30 to 0.60	%	
Across Flow : 24 hr	0.50 to 0.80	%	
Water Absorption			
24 hr, 50% RH	0.13	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.21	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4810	MPa	ASTM D638
--	4410	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	81.0	MPa	ASTM D638
Yield	79.0	MPa	ISO 527-2/5
Break ³	78.0	MPa	ASTM D638
Break	78.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.9	%	ASTM D638
Yield	2.9	%	ISO 527-2/5
Break ⁵	3.1	%	ASTM D638
Break	3.1	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	4200	MPa	ASTM D790
-- ⁷	4160	MPa	ISO 178
Flexural Strength ⁸ (Break, 50.0 mm Span)	106	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	120	J/m	ASTM D256
23°C ⁹	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	490	J/m	ASTM D4812
23°C ¹⁰	34	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	19.2	J	ASTM D3763
--	7.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	138	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	137	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	130	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	128	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	6.0E-5	cm/cm/°C	
Transverse : -30 to 30°C	6.7E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	232 to 243	°C	
Middle Temperature	249 to 260	°C	
Front Temperature	260 to 271	°C	
Processing (Melt) Temp	249 to 271	°C	
Mold Temperature	37.8 to 82.2	°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.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*4		
10.	80*10*4		
11.	80*10*4 mm		
12.	80*10*4 mm		

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