

LNP™ THERMOCOMP™ DF004P compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* DF004P is a compound based on Polycarbonate resin containing 20% Glass Fiber. Added features of this material include:
Exceptional Processing.

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

Product reorder name: DF004P

General Information			
UL YellowCard	E121562-101284522		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Good Processability		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792
Molding Shrinkage			
Flow : 24 hr	0.20	%	ASTM D955
Across Flow : 24 hr	0.70	%	ASTM D955
Across Flow : 24 hr	0.67	%	ISO 294-4
Flow : 24 hr	0.23	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.12	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.19	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6200	MPa	ASTM D638
--	6050	MPa	ISO 527-2/1
Tensile Strength			
Break	104	MPa	ASTM D638
Break	102	MPa	ISO 527-2
Tensile Elongation (Break)	3.2	%	ASTM D638, ISO 527-2
Flexural Modulus			
--	6170	MPa	ASTM D790
--	5990	MPa	ISO 178
Flexural Strength			
--	173	MPa	ASTM D790
--	163	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	75	J/m	ASTM D256

23°C ²	9.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	710	J/m	ASTM D4812
23°C ³	48	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	8.85	J	ASTM D3763
--	2.36	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	138	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	139	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	3.3E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	3.4E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	6.9E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	5.5E-5	cm/cm/°C	ISO 11359-2
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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