

LNP™ THERMOCOMP™ DF006ER compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DF006ER is a compound based on Polycarbonate resin containing Glass Fiber. Added features of this material include: Easy Molding, Mold Release.

Also known as: LNP* THERMOCOMP* Compound DF1006EMMR

Product reorder name: DF006ER

General Information			
UL YellowCard	E45329-101344450	E45329-101344593	
Filler / Reinforcement	Glass fiber reinforced material		
Additive	demoulding		
Features	Good formability		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.42	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9000	MPa	ISO 527-2/1
Tensile Stress (Break)	125	MPa	ISO 527-2/5
Tensile Strain (Break)	2.1	%	ISO 527-2/5
Flexural Modulus ¹	7200	MPa	ISO 178
Flexural Stress	180	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ² (23°C)	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	40	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, unannealed, 64.0mm span	144	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 64.0mm span	140	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 60°C	2.3E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 60°C	6.4E-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 - 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.	2.0 mm/min	
2.	80*10*4	
3.	80*10*4	
4.	80*10*4 mm	

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Recommended distributors for this material

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