

LNP™ THERMOCOMP™ DC006 compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LNP THERMOCOMP* DC006 is a compound based on Polycarbonate resin containing Carbon Fiber. This product is also known as THERMOCOMP* DC-1006.

Also known as: LNP* THERMOCOMP* Compound DC-1006

Product reorder name: DC006

General Information			
UL YellowCard	E207780-101191343		
Filler / Reinforcement	Carbon Fiber		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow	0.090	%	Internal Method
Flow : 24 hr	0.10 to 0.20	%	ASTM D955
Across Flow	0.33	%	Internal Method
Across Flow : 24 hr	0.20 to 0.40	%	ASTM D955
Water Absorption (24 hr, 50% RH)	0.12	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	15900	MPa	ASTM D638
--	15800	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	141	MPa	ASTM D638
Yield	141	MPa	ISO 527-2/5
Break ³	141	MPa	ASTM D638
Break	141	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	1.9	%	ASTM D638
Yield	1.8	%	ISO 527-2/5
Break ⁵	1.9	%	ASTM D638
Break	1.8	%	ISO 527-2/5
Flexural Modulus ⁶	14300	MPa	ISO 178
Flexural Stress			
--	192	MPa	ISO 178
Yield, 50.0 mm Span ⁷	195	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	69	J/m	ASTM D256
23°C ⁸	6.3	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	590	J/m	ASTM D4812
23°C ⁹	44	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	12.0	J	ASTM D3763
--	4.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	147	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	148	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	142	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	143	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	2.4E-5	cm/cm/°C	ASTM E831
Flow : 23 to 60°C	4.4E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	1.1E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 60°C	2.0E-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.	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.	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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