

LNP™ THERMOCOMP™ DF004ER compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* DF004ER is a compound based on Polycarbonate resin containing 20% Glass Fiber. Added features of this material include: Easy Molding. Mold Release.

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

Product reorder name: DF004ER

General Information			
UL YellowCard	E121562-101344608		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Mold Release		
Features	Good Mold Release		
	Good Moldability		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.20 to 0.30	%	ASTM D955, ISO 294-4
Across Flow : 24 hr	0.40 to 0.50	%	ASTM D955
Across Flow : 24 hr	0.43 to 0.50	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.11	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.17	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5650	MPa	ASTM D638
--	5630	MPa	ISO 527-2/1
Tensile Strength			
Break	96.8	MPa	ASTM D638
Break	96.0	MPa	ISO 527-2
Tensile Elongation			
Break	3.7	%	ASTM D638
Break	3.8	%	ISO 527-2
Flexural Modulus			
--	5580	MPa	ASTM D790
--	5750	MPa	ISO 178
Flexural Strength	166	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	140	J/m	ASTM D256
23°C ²	15	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	850	J/m	ASTM D4812
23°C ³	54	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	16.6	J	ASTM D3763
--	6.18	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	140	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	141	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	4.2E-5	cm/cm/°C	
Transverse : -40 to 40°C	5.4E-5	cm/cm/°C	
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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