LNP™ THERMOCOMP™ DF004RXP compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DF004RXP is a compound based on Polycarbonate resin containing 20% Glass Fiber. Some light color grades may have lower impact data than natural and black. Added features include: Mold Release, UL
Also known as: LNP* THERMOCOMP* Compound DF004RXP
Product reorder name: DF004RXP

General Information			
UL YellowCard	E121562-101345271		
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	demoulding		
Features	Good demoulding performance		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.35	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.20 - 0.40	%	ASTM D955
Transverse flow: 24 hours	0.60 - 0.80	%	ASTM D955
Water Absorption			
24 hr, 50% RH	0.13	%	ASTM D570
23°C, 24 hr	0.17	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
-- [1]	6100	MPa	ASTM D638
--	5730	MPa	ISO 527-2/1
Tensile Strength			
Yield [2]	105	MPa	ASTM D638
Yield	105	MPa	ISO 527-2/5
Fracture [3]	102	MPa	ASTM D638
Fracture	104	MPa	ISO 527-2/5
Tensile Elongation			
Yield [4]	2.9	%	ASTM D638
Yield	3.1	%	ISO 527-2/5
Fracture [5]	3.3	%	ASTM D638
Fracture	3.4	%	ISO 527-2/5
Flexural Modulus			
50.0mm span [6]	6070	MPa	ASTM D790

-- [7]	5890	MPa	ISO 178
Flexural Stress			
--	163	MPa	ISO 178
Yield, 50.0mm span [8]	173	MPa	ASTM D790
Fracture, 50.0mm span [9]	169	MPa	ASTM D790
Flexural Strain at Break [10]	3.7	%	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	130	J/m	ASTM D256
23°C, Light & White Colors	98	J/m	ASTM D256
23°C, Natural & Black Colors	130	J/m	ASTM D256
23°C [11]	12	kJ/m²	ISO 180/1A
Unnotched Izod Impact			
23°C	900	J/m	ASTM D4812
23°C [12]	53	kJ/m²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	24.5	J	ASTM D3763
--	5.08	J	ISO 6603-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	141	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span [13]	141	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM D696
Flow: -30 to 30°C	2.9E-5	cm/cm/°C	ASTM D696
Lateral: -30 to 30°C	5.4E-5	cm/cm/°C	ASTM D696
Flammability	**Nominal Value**		**Test Method**
Flame Rating (0.750 to 3.00 mm)	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature	110	°C	
Drying Time	3.0 - 6.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	260 - 280	°C	
Middle Temperature	270 - 290	°C	
Front Temperature	280 - 300	°C	
Nozzle Temperature	285 - 305	°C	
Processing (Melt) Temp	285 - 310	°C	
Mold Temperature	80.0 - 110	°C	
Back Pressure	0.100 - 0.300	MPa	
Screw Speed	50 - 90	rpm	
NOTE			
1.	50 mm/min		
2.	Type 1, 5.0 mm/min		

3.	Type 1, 5.0 mm/min
4.	Type 1, 5.0 mm/min
5.	Type 1, 5.0 mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	1.3 mm/min
10.	2 mm/min
11.	80*10*4
12.	80*10*4
13.	80*10*4 mm

Recommended distributors for this material

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