

LNP™ COLORCOMP™ D1000 compound

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LNP COLORCOMP D1000 is a compound based on Polycarbonate resin containing Unfilled Custom Color

Also known as: LNP* COLORCOMP* Compound D-1000

Product reorder name: D1000

General Information			
UL YellowCard	E45329-101357439		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.60 to 0.90	%	Internal Method
Water Absorption (23°C, 24 hr)	0.18	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2450	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	67.0	MPa	
Break	61.0	MPa	
Tensile Strain (Break)	6.8	%	ISO 527-2/50
Flexural Stress	91.0	MPa	ISO 178
Flexural Strain at Break ¹	7.1	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	7.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	120	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	132	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	120	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	6.8E-5	cm/cm/°C	
Transverse : 23 to 60°C	7.5E-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. | 2 mm/min |
| 2. | 80*10*4 |
| 3. | 80*10*4 |
| 4. | 80*10*4 mm |

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