

LNP™ THERMOCOMP™ DF004ER compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DF004ER 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 DF-1004 EM MR

Product reorder name: DF004ER

General Information			
UL YellowCard	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	1.33	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	0.25 - 0.45	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6100	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	97.0	MPa	ISO 527-2/5
Fracture	120	MPa	ISO 527-2/5
Tensile Strain			ISO 527-2/5
Yield	2.6	%	ISO 527-2/5
Fracture	3.6	%	ISO 527-2/5
Flexural Modulus ²	5500	MPa	ISO 178
Flexural Stress	178	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ³ (23°C)	13	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	55	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
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
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	V-2		UL 94
3.00 mm	V-1		UL 94
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. | Tensile Bar |
| 2. | 2.0 mm/min |
| 3. | 80*10*4 |
| 4. | 80*10*4 |
| 5. | 80*10*4 mm |

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