

LNP™ THERMOTUF™ DF004PSI compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

Glass Reinforced Polycarbonate. High Flow Ductile, High Chemical Resistance

General Information			
Filler / Reinforcement	Glass Fiber		
Features	Ductile		
	Good Chemical Resistance		
	High Flow		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	10.0	cm ³ /10min	ASTM D1238
Molding Shrinkage			Internal Method
Flow	0.30 to 0.50	%	
Across Flow	0.30 to 0.50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6100	MPa	ASTM D638
--	5960	MPa	ISO 527-2/1
Tensile Strength			
Break ²	99.0	MPa	ASTM D638
Break	99.0	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.9	%	ASTM D638
Break	2.9	%	ISO 527-2/5
Flexural Modulus ⁴ (50.0 mm Span)	5380	MPa	ASTM D790
Flexural Strength ⁵ (Break, 50.0 mm Span)	147	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	16	kJ/m ²	ISO 179/2C
Charpy Unnotched Impact Strength (23°C)	48	kJ/m ²	ISO 179/2U
Notched Izod Impact (23°C)	160	J/m	ASTM D256
Unnotched Izod Impact (23°C)	630	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	130	°C	

1.8 MPa, Unannealed, 3.20 mm	126	°C
CLTE		ASTM E831
Flow : -40 to 40°C	2.5E-5	cm/cm/°C
Transverse : -40 to 40°C	6.0E-5	cm/cm/°C
Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	3.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	260 to 280	°C
Middle Temperature	270 to 290	°C
Front Temperature	280 to 300	°C
Nozzle Temperature	285 to 305	°C
Processing (Melt) Temp	285 to 310	°C
Mold Temperature	80.0 to 110	°C
Back Pressure	0.100 to 0.300	MPa
Screw Speed	50 to 90	rpm
NOTE		
1.	5.0 mm/min	
2.	Type I, 5.0 mm/min	
3.	Type I, 5.0 mm/min	
4.	1.3 mm/min	
5.	1.3 mm/min	

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