

LNP™ THERMOCOMP™ DF008 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* DF008 is a compound based on Polycarbonate resin containing 40% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound DF-1008

Product reorder name: DF008

General Information			
UL YellowCard	E121562-101282746		
Filler / Reinforcement	Glass Fiber,40% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.52	g/cm ³	ASTM D792
--	1.12	g/cm ³	ISO 1183, ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	1.0 to 3.0	%	
Across Flow : 24 hr	0.30 to 0.50	%	
Water Absorption			
24 hr, 50% RH	0.080	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.080	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	22400	MPa	ASTM D638
--	14400	MPa	ISO 527-2/1
Tensile Strength			
Break ²	141	MPa	ASTM D638
Break	132	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	6.5	%	ASTM D638
Break	6.9	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	11600	MPa	ASTM D790
-- ⁵	11200	MPa	ISO 178
Flexural Strength ⁶ (Break, 50.0 mm Span)	205	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	150	J/m	ASTM D256
23°C ⁷	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			

23°C	720	J/m	ASTM D4812
23°C ⁸	45	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	138	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	141	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	134	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	140	°C	ISO 75-2/Af
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.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		
10.	80*10*4 mm		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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