

LNP™ THERMOCOMP™ DF004 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DF004 is a compound based on Polycarbonate resin containing Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound DF-1004

Product reorder name: DF004

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183, ASTM D792
Molding Shrinkage			
Flow: 24 hours	0.20	%	ASTM D955
Transverse flow: 24 hours	0.50	%	ASTM D955
Vertical flow direction: 24 hours	0.45	%	ISO 294-4
Flow direction: 24 hours	0.20	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5520	MPa	ASTM D638
--	5940	MPa	ISO 527-2/1
Tensile Strength			
Fracture	91.7	MPa	ASTM D638
Fracture	102	MPa	ISO 527-2
Tensile Elongation			
Fracture	9.5	%	ASTM D638
Fracture	8.0	%	ISO 527-2
Flexural Modulus			
--	5520	MPa	ASTM D790
--	6000	MPa	ISO 178
Flexural Strength			
--	149	MPa	ASTM D790
--	148	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	130	J/m	ASTM D256
23°C ²	8.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	960	J/m	ASTM D4812

23°C ³	59	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	144	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	139	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁴	141	°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 - 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.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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