

LNP™ THERMOTUF™ DF008EI compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOTUF DF008EI is a compound based on Polycarbonate resin containing 40% Glass Fiber. Added features of this material include: Easy Molding, Mold Release, High Impact.

Also known as: LNP* THERMOTUF* Compound DF-1008 EM HI MR

Product reorder name: DF008EI

General Information			
UL YellowCard	E121562-101345269		
Filler / Reinforcement	Glass Fiber,40% Filler by Weight		
Additive	Mold Release		
Features	Good Moldability		
	High Impact Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.51	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Across Flow : 24 hr	0.30	%	ASTM D955
Across Flow : 24 hr	0.33	%	ISO 294-4
Flow : 24 hr	0.040	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	12600	MPa	ASTM D638
--	11100	MPa	ISO 527-2/1
Tensile Strength			
Yield	132	MPa	ASTM D638
Yield	129	MPa	ISO 527-2
Break	132	MPa	ASTM D638
Break	130	MPa	ISO 527-2
Tensile Elongation			
Yield	2.2	%	ASTM D638
Yield	2.0	%	ISO 527-2
Break	2.2	%	ASTM D638
Break	2.0	%	ISO 527-2
Flexural Modulus			
--	10600	MPa	ASTM D790
--	10100	MPa	ISO 178
Flexural Strength			

--	200	MPa	ASTM D790
--	140	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	160	J/m	ASTM D256
23°C ²	17	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	840	J/m	ASTM D4812
23°C ³	52	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	23.1	J	ASTM D3763
--	7.69	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	134	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	135	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	2.5E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	2.7E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	4.1E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	4.3E-5	cm/cm/°C	ISO 11359-2
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.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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