LNP™ COLORCOMP™ COMPOUND D1000P

D-1000 EP
REGION ASIA

DESCRIPTION

LNP COLORCOMP D1000P is an unfilled Polycarbonate. Added feature of this grade is: Exceptional Processing.

TYPICAL PROPERTY VALUES

Revision 20181101

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	62	MPa	ASTM D 638
Tensile Stress, break	56	MPa	ASTM D 638
Tensile Strain, yield	5.3	%	ASTM D 638
Tensile Strain, break	78.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	2060	MPa	ASTM D 638
Flexural Modulus	2750	MPa	ASTM D 790
Tensile Stress, yield	64	MPa	ISO 527
Tensile Stress, break	59	MPa	ISO 527
Tensile Strain, yield	5.6	%	ISO 527
Tensile Strain, break	87	%	ISO 527
Tensile Modulus, 1 mm/min	2210	MPa	ISO 527
Flexural Stress	81	MPa	ISO 178
Flexural Modulus	2300	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	544	J/m	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	13	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	123	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	124	°C	ISO 75/Af
PHYSICAL			
Density	1.2	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.6 – 0.8	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.7 – 0.9	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.65	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.75	%	ISO 294
Density	1.19	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	300 – 315	°C	
Front - Zone 3 Temperature	310 – 320	°C	
Middle - Zone 2 Temperature	305 – 315	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Rear - Zone 1 Temperature	295 – 305	°C	
Mold Temperature	80 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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