LNP™ THERMOCOMP™ COMPOUND DF006ER

DF-1006 EM MR
REGION EUROPE

DESCRIPTION

LNP THERMOCOMP* DF006ER is a compound based on Polycarbonate resin containing 30% Glass Fiber. Added features of this material include: Easy Molding, Mold Release.

TYPICAL PROPERTY VALUES

Revision 20191031

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	125	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.1	%	ISO 527
Tensile Modulus, 1 mm/min	9000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	180	MPa	ISO 178
Flexural Modulus, 2 mm/min	7200	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	40	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	13	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	2.3E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	6.4E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	144	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	140	°C	ISO 75/Af
PHYSICAL			
Density	1.42	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	305 – 325	°C	
Front - Zone 3 Temperature	320 – 330	°C	
Middle - Zone 2 Temperature	310 – 320	°C	
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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