LNP™ THERMOCOMP™ COMPOUND DF006P

DF-1006 EP

DESCRIPTION

LNP THERMOCOMP* DF006P is a compound based on Polycarbonate resin containing 30% Glass Fiber. Added features of this material include: Exceptional Processing.

TYPICAL PROPERTY VALUES

Revision 20191217

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	124	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	124	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	10480	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	165	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	165	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	8720	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	125	MPa	ISO 527
Tensile Stress, break, 5 mm/min	125	MPa	ISO 527
Tensile Modulus, 1 mm/min	10010	MPa	ISO 527
IMPACT			
Izod Impact, unnotched, 23°C	774	J/m	ASTM D 4812
Izod Impact, notched, 23°C	112	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	13	J	ASTM D 3763
Multiaxial Impact	2	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	47	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	134	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	131	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	134	°C	ISO 75/Af
Relative Temp Index, Elec (1)	80	°C	UL 746B
Relative Temp Index, Mech w/impact (1)	80	°C	UL 746B
Relative Temp Index, Mech w/o impact (1)	80	°C	UL 746B
PHYSICAL			
Density	1.424	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.15	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.67	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.09	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.51	%	ISO 294
Density	1.42	g/cm³	ISO 1183
FLAME CHARACTERISTICS (1)			

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
UL Yellow Card Link	E121562-101284106	-	-
UL Recognized, 94V-0 Flame Class Rating	≥3	mm	UL 94
UL Recognized, 94V-2 Flame Class Rating	≥1.5	mm	UL 94
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	

(1) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

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