LNP™ THERMOCOMP™ COMPOUND DF008ERH

DF-1008 EM MR HC

DESCRIPTION

LNP THERMOCOMP* DF008ERH is a compound based on Polycarbonate resin containing 40% Glass Fiber. Added features of this material include: Easy Molding, Mold Release, Healthcare.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	136	MPa	ASTM D 638
Tensile Strain, break	2.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	11810	MPa	ASTM D 638
Flexural Stress	204	MPa	ASTM D 790
Flexural Modulus	11260	MPa	ASTM D 790
Tensile Stress, break	136	MPa	ISO 527
Tensile Strain, break	2.2	%	ISO 527
Tensile Modulus, 1 mm/min	11170	MPa	ISO 527
Flexural Stress	203	MPa	ISO 178
Flexural Modulus	10970	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	806	J/m	ASTM D 4812
Izod Impact, notched, 23°C	218	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	53	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	11	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	136	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.25E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	3.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	3.26E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	3.51E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	137	°C	ISO 75/Af
PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.93	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.4	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.16	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.35	%	ISO 294
Moisture Absorption (23°C / 50% RH)	0.12	%	ISO 62
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	4	hrs	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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