LNP™ THERMOCOMP™ COMPOUND DZ004

DF-1004 M
REGION ASIA

DESCRIPTION

LNP THERMOCOMP DZ004 is a compound based on Polycarbonate resin containing 20% Milled Glass.

TYPICAL PROPERTY VALUES

Revision 20191031

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	60	MPa	ASTM D 638
Tensile Strain, break	4.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	3700	MPa	ASTM D 638
Flexural Stress	96	MPa	ASTM D 790
Flexural Modulus	3500	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	1142	J/m	ASTM D 4812
Izod Impact, notched, 23°C	58	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	136	°C	ASTM D 648
PHYSICAL			
Density	1.41	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.3	%	ASTM D 955
ELECTRICAL			
Volume Resistivity	40400000000000000 – 59000000000000000	Ohm-cm	ASTM D 257
Surface Resistivity	3.09E+13 – 3.87E+13	Ohm	ASTM D 257
Dielectric Strength, in air, 1.6 mm	24.3	kV/mm	ASTM D 149
Dissipation Factor, 1 MHz	0.0083	-	ASTM D 150
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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