LNP™ THERMOCOMP™ COMPOUND NF004

PCA-F-1004
REGION ASIA

DESCRIPTION

LNP THERMOCOMP NF004 is a compound based on PC+ABS resin containing 20% Glass Fiber.

TYPICAL PROPERTY VALUES

Revision 20181220

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	97	MPa	ASTM D 638
Tensile Strain, break	2.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	6890	MPa	ASTM D 638
Flexural Stress	137	MPa	ASTM D 790
Flexural Modulus	6200	MPa	ASTM D 790
Tensile Stress, break	95	MPa	ISO 527
Tensile Strain, break	2.5	%	ISO 527
Tensile Modulus, 1 mm/min	6480	MPa	ISO 527
Flexural Stress	143	MPa	ISO 178
Flexural Modulus	6000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	598	J/m	ASTM D 4812
Izod Impact, notched, 23°C	117	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	18	J	ASTM D 3763
Multiaxial Impact	5	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	37	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	11	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	138	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	135	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.74E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	3.24E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.7E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	3.2E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	140	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	134	°C	ISO 75/Af
PHYSICAL			
Density	1.3	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.6	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.41	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.58	%	ISO 294

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Density	1.3	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	250 – 270	°C	
Front - Zone 3 Temperature	260 – 270	°C	
Middle - Zone 2 Temperature	250 – 260	°C	
Rear - Zone 1 Temperature	230 – 245	°C	
Mold Temperature	40 – 80	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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