

LNP™ THERMOTUF™ COMPOUND DF004PSI

REGION ASIA

DESCRIPTION

Glass Reinforced Polycarbonate. High Flow Ductile, High Chemical Resistance

TYPICAL PROPERTY VALUES

Revision 20170816

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	99	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.9	%	ASTM D 638
Tensile Modulus, 5 mm/min	6100	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	147	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	5380	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	99	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.9	%	ISO 527
Tensile Modulus, 1 mm/min	5960	MPa	ISO 527
IMPACT			
Charpy Impact, unnotched, 23°C	48	kJ/m ²	ISO 179/2C
Izod Impact, unnotched, 23°C	627	J/m	ASTM D 4812
Izod Impact, notched, 23°C	160	J/m	ASTM D 256
Charpy Impact, notched, 23°C	16	kJ/m ²	ISO 179/2C
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	130	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	126	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ASTM E 831
PHYSICAL			
Density	1.33	g/cm ³	ASTM D 792
Mold Shrinkage, flow (5)	0.3 – 0.5	%	SABIC method
Mold Shrinkage, xflow (5)	0.3 – 0.5	%	SABIC method
Melt Volume Rate, MVR at 300°C/1.2 kg	10	cm ³ /10 min	ASTM D 1238
INJECTION MOLDING			
Drying Temperature	110	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	3 – 6	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	285 – 310	°C	
Nozzle Temperature	285 – 305	°C	
Front - Zone 3 Temperature	280 – 300	°C	
Middle - Zone 2 Temperature	270 – 290	°C	
Rear - Zone 1 Temperature	260 – 280	°C	
Mold Temperature	80 – 110	°C	
Back Pressure	0.1 – 0.3	MPa	
Screw Speed	50 – 90	rpm	

DISCLAIMER

The information contained herein may include typical properties of our products or their typical performances when used in certain typical applications. Actual properties of our products, in particular when used in conjunction with any third party material(s) or for any non-typical applications, may differ from typical properties.

It is the customer's responsibility to inspect and test our product(s) in order to satisfy itself as to the suitability of the product(s) for its and its customers particular purposes. The customer is responsible for the appropriate, safe and legal use, processing and handling of all product(s) purchased from us.

Nothing herein is intended to be nor shall it constitute a warranty whatsoever, in particular, warranty of merchantability or fitness for a particular purpose.

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