

**Product Texts**

LNP THERMOCOMP NF004 compound is based on Polycarbonate/Acrylonitrile Butadiene Styrene (PC/ABS) blend containing 20% glass fiber.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.4	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.6	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	6480	MPa	ISO 527
Stress at break	95	MPa	ISO 527
Strain at break	2.5	%	ISO 527
Flexural modulus	6000	MPa	ISO 178
Flexural strength	143	MPa	ISO 178
Izod impact strength, +23°C, 4mm	37	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	11	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Modulus	6890	MPa	ASTM D 638
Tensile Strength at Break	97	MPa	ASTM D 638
Elongation at Break	2.5	%	ASTM D 638
Flexural Modulus	6200	MPa	ASTM D 790
Flexural Strength	137	MPa	ASTM D 790
Izod Impact notched, 1/8 in	117	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	598	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	134	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	140	°C	ISO 75-1/-2
<b>ASTM Data</b>			
DTUL @ 66 psi	138	°C	ASTM D 648
DTUL @ 264 psi	135	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1300	kg/m <sup>3</sup>	ISO 1183
Water Absorption, 24hr	0.1	%	ASTM D 570
Density	1300	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	230 - 245	°C	-
Zone 2	250 - 260	°C	-
Zone 3	260 - 270	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.2 - 0.3	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific