

**Product Texts**

LNP THERMOCOMP DF006AT compound is based on Polycarbonate (PC) resin containing 30% glass fiber. Added features of this grade include: Transparent/Translucent, High stiffness/Strength.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	8	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-
Mold Shrinkage, MD	0.002	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.004	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	8500	MPa	ISO 527
Stress at break	117	MPa	ISO 527
Strain at break	2.4	%	ISO 527
Flexural modulus, 23°C	6800	MPa	ISO 178
Flexural strength	158	MPa	ISO 178
Charpy impact strength, +23°C	51.2	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	44.2	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	13	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	10.4	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	49.8	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	11.7	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	10.4	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
<b>ASTM Data</b>			
Tensile Modulus	8400	MPa	ASTM D 638
Tensile Strength at Break	117	MPa	ASTM D 638
Elongation at Break	2.5	%	ASTM D 638
Flexural Modulus	7600	MPa	ASTM D 790
Flexural Strength	171	MPa	ASTM D 790
Izod Impact notched, 1/8 in	132	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	108	J/m	ASTM D 256
Temperature	-30	°C	-
Izod Impact unnotched, 1/8 in	656	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	117	°C	ISO 75-1/-2
Vicat softening temperature, B	125	°C	ISO 306
Coeff. of linear therm. expansion, parallel	18	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	62	E-6/K	ISO 11359-1/-2
<b>ASTM Data</b>			
Coefficient of Thermal Expansion, MD	21	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	65	E-6/K	ASTM D 696
DTUL @ 264 psi	118	°C	ASTM D 648
Vicat Temperature	126	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1410	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	270 - 320	°C	-
Mold temperature	95 - 110	°C	-

Zone 1	<b>270 - 280</b>	°C	-
Zone 2	<b>280 - 295</b>	°C	-
Zone 3	<b>290 - 310</b>	°C	-
Nozzle temperature	<b>290 - 310</b>	°C	-
Screw speed	<b>40 - 70</b>	rpm	-
Back pressure	<b>0.3 - 0.7</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

Transparent, Translucent

**Applications**

Automotive, IT / Business Machine

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America