

Product Texts

LNP THERMOCOMP DF002ERH compound is based on Polycarbonate (PC) resin containing 10% glass fiber. Added features of this grade include: Easy Molding, Healthcare, Mold Release.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	0.4	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.5	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	4100	MPa	ISO 527
Stress at break	84	MPa	ISO 527
Strain at break	3.6	%	ISO 527
Flexural modulus	3920	MPa	ISO 178
Flexural strength	117	MPa	ISO 178
Izod impact strength, +23°C, 4mm	61	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	8	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	4170	MPa	ASTM D 638
Tensile Strength at Break	83	MPa	ASTM D 638
Elongation at Break	3.8	%	ASTM D 638
Flexural Modulus	4280	MPa	ASTM D 790
Flexural Strength	149	MPa	ASTM D 790
Izod Impact notched, 1/8 in	97	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	929	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	137	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	141	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 66 psi	141	°C	ASTM D 648
DTUL @ 264 psi	136	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1270	kg/m ³	ISO 1183
Water Absorption, 24hr	0.15	%	ASTM D 570
Density	1270	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	305 - 325	°C	-
Mold temperature	80 - 110	°C	-
Zone 1	295 - 305	°C	-
Zone 2	310 - 320	°C	-
Zone 3	320 - 330	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.2 - 0.3	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

North America, Europe, Asia Pacific