LNP™ THERMOCOMP™ Compound PCAF04FRHH
Europe-Africa-Middle East: COMMERCIAL

LNP* THERMOCOMP* PCA04FRHH is a 20 % glass reinforced PC+ABS blend without chlorinated or brominated flame retardants. LNP* THERMOCOMP* complies with the material requirements as specified in TCO"99 and Blue Angel ecolabels.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break, 5 mm/min	85	MPa	ISO 527
Tensile Modulus, 1 mm/min	6200	MPa	ISO 527
Flexural Stress, break, 2 mm/min	130	MPa	ISO 178
Flexural Strain, break, 2 mm/min	2.5	%	ISO 178
Flexural Modulus, 2 mm/min	5800	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	23	kJ/m²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/120	130	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	118	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage, flow (5)	0.2 - 0.4	%	SABIC Method
Mold Shrinkage, xflow (5)	0.3 - 0.5	%	SABIC Method
Density	1.32	g/cm³	ISO 1183
Melt Volume Rate, MVR at 260°C/5.0 kg	8	cm³/10 min	ISO 1133
ELECTRICAL			
Comparative Tracking Index	150	V	IEC 60112
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1.5	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.5 mm	825	°C	IEC 60695-2-13

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.
(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
(4) Internal measurements according to UL standards.
(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	230 - 270	°C
Nozzle Temperature	220 - 260	°C
Front - Zone 3 Temperature	230 - 270	°C
Middle - Zone 2 Temperature	220 - 260	°C
Rear - Zone 1 Temperature	200 - 230	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	50 - 70	°C

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