



LNP™ COLORCOMP™ Compound D1000FL

Americas: COMMERCIAL

Also known as: LNP™ COLORCOMP™ Compound D-1000 LE SM

Product reorder name: D1000FL

LNP COLORCOMP D1000FL is an unfilled compound based on Polycarbonate resin. Added features of this grade are: Superior Molding, Low Extractible.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	650	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	6	%	ASTM D 638
Tensile Modulus, 50 mm/min	24300	kgf/cm ²	ASTM D 638
THERMAL			
Thermal Conductivity	0.17	W/m-°C	ASTM E 1530
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	125	°C	ISO 75/Af
PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.3	%	ASTM D 570
Density	1.2	g/cm ³	ISO 1183



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	305 - 325	°C
Front - Zone 3 Temperature	320 - 330	°C
Middle - Zone 2 Temperature	310 - 320	°C
Rear - Zone 1 Temperature	295 - 305	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm