



LNP™ COLORCOMP™ Compound D1000P

Americas: COMMERCIAL

Also known as: LNP™ COLORCOMP™ Compound D-1000 EP

Product reorder name: D1000P

LNP COLORCOMP D1000P is an unfilled Polycarbonate. Added feature of this grade is: Exceptional Processing.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	630	kgf/cm ²	ASTM D 638
Tensile Stress, break	570	kgf/cm ²	ASTM D 638
Tensile Strain, yield	5.3	%	ASTM D 638
Tensile Strain, break	78.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	21000	kgf/cm ²	ASTM D 638
Flexural Modulus	28100	kgf/cm ²	ASTM D 790
Tensile Stress, yield	64	MPa	ISO 527
Tensile Stress, break	59	MPa	ISO 527
Tensile Strain, yield	5.6	%	ISO 527
Tensile Strain, break	87	%	ISO 527
Tensile Modulus, 1 mm/min	2210	MPa	ISO 527
Flexural Stress	81	MPa	ISO 178
Flexural Modulus	2300	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	55	cm-kgf/cm	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	13	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	123	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	124	°C	ISO 75/Af
PHYSICAL			
Density	1.2	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.6 - 0.8	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.7 - 0.9	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.65	%	ISO 294



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PHYSICAL			
Mold Shrinkage, xflow, 24 hrs (5)	0.75	%	ISO 294
Density	1.19	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	300 - 315	°C
Front - Zone 3 Temperature	310 - 320	°C
Middle - Zone 2 Temperature	305 - 315	°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