



LNP™ THERMOCOMP™ Compound DF004

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound DF-1004

Product reorder name: DF004

LNP THERMOCOMP DF004 is a compound based on Polycarbonate resin containing 20% Glass Fiber.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	930	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	9.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	56200	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1500	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	56200	kgf/cm ²	ASTM D 790
Tensile Modulus, 1 mm/min	5940	MPa	ISO 527
IMPACT			
Izod Impact, unnotched, 23°C	98	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	13	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	59	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	144	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	139	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Af
PHYSICAL			
Density	1.35	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.2	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.5	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.2	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.45	%	ISO 294
Density	1.35	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