



LNP™ THERMOCOMP™ Compound DF004XXC

Europe-Africa-Middle East: COMMERCIAL

Polycarbonate compound, containing Glass Fiber

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 5 mm/min	121	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.1	%	ISO 527
Tensile Modulus, 1 mm/min	6800	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	188	MPa	ISO 178
Flexural Modulus, 2 mm/min	6100	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	65	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	12	kJ/m ²	ISO 180/1A
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	143	°C	ISO 75/Af
PHYSICAL			
Density	1.36	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