



LNP™ THERMOCOMP™ Compound DF006ER

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound DF-1006 EM MR

Product reorder name: DF006ER

LNP THERMOCOMP™ DF006ER is a compound based on Polycarbonate resin containing 30% Glass Fiber. Added features of this material include: Easy Molding, Mold Release.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1350	kgf/cm ²	ASTM D 638
Tensile Strain, break	2.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	97000	kgf/cm ²	ASTM D 638
Flexural Stress	2090	kgf/cm ²	ASTM D 790
Flexural Modulus	89200	kgf/cm ²	ASTM D 790
Tensile Stress, break	106	MPa	ISO 527
Tensile Strain, break	2.2	%	ISO 527
Tensile Modulus, 1 mm/min	7500	MPa	ISO 527
Flexural Stress	196	MPa	ISO 178
Flexural Modulus	8500	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	88	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	13	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	83	cm-kgf	ASTM D 3763
Multiaxial Impact	43	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	60	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	13	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	136	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	138	°C	ISO 75/Af
PHYSICAL			
Density	1.425	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.1	%	ASTM D 955



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PHYSICAL			
Mold Shrinkage, xflow, 24 hrs (5)	0.5	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.11	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.48	%	ISO 294
Density	1.42	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