



LNP™ THERMOCOMP™ Compound DF006P

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound DF-1006 EP

Product reorder name: DF006P

LNP THERMOCOMP™ DF006P is a compound based on Polycarbonate resin containing 30% Glass Fiber. Added features of this material include: Exceptional Processing.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1270	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1270	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	106800	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1680	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1680	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	89000	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	125	MPa	ISO 527
Tensile Stress, break, 5 mm/min	125	MPa	ISO 527
Tensile Modulus, 1 mm/min	10010	MPa	ISO 527
IMPACT			
Izod Impact, unnotched, 23°C	78	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	11	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	132	cm-kgf	ASTM D 3763
Multiaxial Impact	22	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	47	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	134	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	131	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	134	°C	ISO 75/Af
PHYSICAL			
Density	1.424	g/cm ³	ASTM D 792



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.15	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.67	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.09	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.51	%	ISO 294
Density	1.42	g/cm ³	ISO 1183
FLAME CHARACTERISTICS			
UL Compliant, 94V-2 Flame Class Rating (3)(4)	1.5	mm	UL 94 by SABIC-IP
UL Compliant, 94V-0 Flame Class Rating (3)(4)	3	mm	UL 94 by SABIC-IP



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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