



LNP™ THERMOCOMP™ Compound DF0081PI

Asia Pacific: COMMERCIAL

LNP THERMOCOMP DF0081PI is a compound based on Polycarbonate resin containing Glass Fiber, Flame Retardant. Added features of this material include: High Modulus, good flatness, Non-Brominated & Non-Chlorinated Flame Retardant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1320	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	129500	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1730	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	101900	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	123	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.7	%	ISO 527
Tensile Modulus, 1 mm/min	12500	MPa	ISO 527
Flexural Strain, break, 2 mm/min	1.9	%	ISO 178
Flexural Modulus, 2 mm/min	10800	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	26	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	8	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	101	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	22	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	9	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	110	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	102	°C	ISO 75/Af
PHYSICAL			
Density	1.54	g/cm ³	ASTM D 792
Mold Shrinkage, flow (5)	0.4	%	SABIC Method
Mold Shrinkage, xflow (5)	0.41	%	SABIC Method



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	110	°C
Drying Time	3 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	285 - 310	°C
Nozzle Temperature	285 - 305	°C
Front - Zone 3 Temperature	280 - 300	°C
Middle - Zone 2 Temperature	270 - 290	°C
Rear - Zone 1 Temperature	260 - 280	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.1 - 0.3	MPa
Screw Speed	50 - 90	rpm