



LNP™ THERMOCOMP™ Compound DFZ22P

Americas: COMMERCIAL

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

Product reorder name: DFZ22P

LNP THERMOCOMP™ DFZ22P is a compound based on Polycarbonate resin containing 10% Glass Fiber, 10% Milled Glass. Added features of this material include: Exceptional Processing.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	680	kgf/cm ²	ASTM D 638
Tensile Strain, break	6	%	ASTM D 638
Tensile Modulus, 50 mm/min	43500	kgf/cm ²	ASTM D 638
Flexural Stress	1260	kgf/cm ²	ASTM D 790
Flexural Modulus	34400	kgf/cm ²	ASTM D 790
Tensile Stress, break	49	MPa	ISO 527
Tensile Strain, break	4.8	%	ISO 527
Tensile Modulus, 1 mm/min	4410	MPa	ISO 527
Flexural Stress	132	MPa	ISO 178
Flexural Modulus	3900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	57	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	71	cm-kgf	ASTM D 3763
Multiaxial Impact	84	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	52	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	132	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	133	°C	ISO 75/Af
PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.6	%	ASTM D 955



LNP™ THERMOCOMP™ Compound DFZ22P

Americas: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Mold Shrinkage, flow, 24 hrs (5)	0.4	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.61	%	ISO 294
Density	1.33	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62



LNP™ THERMOCOMP™ Compound DFZ22P

Americas: COMMERCIAL

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