



LNP™ THERMOTUF™ Compound DF008EI

Americas: COMMERCIAL

Also known as: LNP™ THERMOTUF™ Compound DF-1008 EM HI MR

Product reorder name: DF008EI

LNP THERMOTUF DF008EI is a compound based on Polycarbonate resin containing 40% Glass Fiber. Added features of this material include: Easy Molding, Mold Release, High Impact.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	1340	kgf/cm ²	ASTM D 638
Tensile Stress, break	1340	kgf/cm ²	ASTM D 638
Tensile Strain, yield	2.2	%	ASTM D 638
Tensile Strain, break	2.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	128800	kgf/cm ²	ASTM D 638
Flexural Stress	2030	kgf/cm ²	ASTM D 790
Flexural Modulus	108200	kgf/cm ²	ASTM D 790
Tensile Stress, yield	129	MPa	ISO 527
Tensile Stress, break	130	MPa	ISO 527
Tensile Strain, yield	2	%	ISO 527
Tensile Strain, break	2	%	ISO 527
Tensile Modulus, 1 mm/min	11060	MPa	ISO 527
Flexural Stress	140	MPa	ISO 178
Flexural Modulus	10090	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	85	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	16	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	235	cm-kgf	ASTM D 3763
Multiaxial Impact	78	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	51	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	16	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	133	°C	ASTM D 648



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
CTE, -40°C to 40°C, flow	2.52E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.14E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	2.66E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	4.25E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	135	°C	ISO 75/Af
PHYSICAL			
Density	1.51	g/cm ³	ASTM D 792
Mold Shrinkage, xflow, 24 hrs (5)	0.3	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.04	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.33	%	ISO 294
Density	1.51	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