LNP™ THERMOTUF™ Compound DF008EI

DF-1008 EM HI MR

DESCRIPTION

LNP THERMOTUF DF008EI compound is based on Polycarbonate (PC) resin containing 40% glass fiber. Added features of this grade include: Easy Molding, Impact Modified.

GENERAL INFORMATION	
Features	Good Processability, High stiffness/Strength, Impact resistant, No PFAS intentionally added
Fillers	Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component
Consumer	Personal Accessory
Electrical and Electronics	Mobile Phone - Computer - Tablets
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yield	132	MPa	ASTM D638
Tensile Stress, break	132	MPa	ASTM D638
Tensile Strain, yield	2.2	%	ASTM D638
Tensile Strain, break	2.2	%	ASTM D638
Tensile Modulus, 50 mm/min	12630	MPa	ASTM D638
Flexural Stress	199	MPa	ASTM D790
Flexural Modulus	10610	MPa	ASTM D790
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 [1]			
Izod Impact, unnotched, 23°C	838	J/m	ASTM D4812
Izod Impact, notched, 23°C	160	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	23	J	ASTM D3763
Multiaxial Impact	7	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	51	kJ/m²	ISO 180/1U

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Izod Impact, notched 80*10*4 +23°C	16	kJ/m²	ISO 180/1A
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	133	°C	ASTM D648
CTE, -40°C to 40°C, flow	2.52E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	4.14E-05	1/°C	ASTM E831
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
Relative Temp Index, Elec [2]	80	°C	UL 746B
Relative Temp Index, Mech w/impact [2]	80	°C	UL 746B
Relative Temp Index, Mech w/o impact [2]	80	°C	UL 746B
PHYSICAL [1]			
Density	1.51	g/cm³	ASTM D792
Mold Shrinkage, xflow, 24 hrs [3]	0.3	%	ASTM D955
Mold Shrinkage, flow, 24 hrs [3]	0.1 – 0.3	%	ISO 294
Mold Shrinkage, xflow, 24 hrs [3]	0.2 – 0.4	%	ISO 294
Density	1.51	g/cm³	ISO 1183
FLAME CHARACTERISTICS [2]			
UL Yellow Card Link	E121562-101345269	-	-
UL Yellow Card Link 2	E207780-101345229	-	-
UL Recognized, 94HB Flame Class Rating	≥0.4	mm	UL 94
INJECTION MOLDING [4]			
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	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

(3) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(4) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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