LNP™ THERMOCOMP™ COMPOUND DF002ERH

DF-1002 EM MR HC

DESCRIPTION

LNP THERMOCOMP DF002ERH compound is based on Polycarbonate (PC) resin containing 10% glass fiber. Added features of this grade include: Easy Molding, Healthcare, Mold Release.

GENERAL INFORMATION	
Features	Good Processability, Healthcare/Formula lock, Enhanced mold release, High stiffness/Strength, No PFAS intentionally added
Fillers	Glass Fiber
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Hygiene and Healthcare	Pharmaceutical Packaging and Drug Delivery, Surgical devices, General Healthcare, Patient Testing
Packaging	Industrial Packaging

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, break	83	MPa	ASTM D638
Tensile Strain, break	3.8	%	ASTM D638
Tensile Modulus, 50 mm/min	4170	MPa	ASTM D638
Flexural Stress	149	MPa	ASTM D790
Flexural Modulus	4280	MPa	ASTM D790
Tensile Stress, break	84	MPa	ISO 527
Tensile Strain, break	3.6	%	ISO 527
Tensile Modulus, 1 mm/min	4100	MPa	ISO 527
Flexural Stress	117	MPa	ISO 178
Flexural Modulus	3920	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched, 23°C	929	J/m	ASTM D4812
Izod Impact, notched, 23°C	97	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	13	J	ASTM D3763
Multiaxial Impact	9	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	61	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	141	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	136	°C	ASTM D648
CTE, -40°C to 40°C, flow	3.81E-05	1/°C	ASTM E831

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 40°C, xflow	5.34E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, flow	3.82E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	5.35E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	137	°C	ISO 75/Af
PHYSICAL (1)			
Density	1.275	g/cm³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.15	%	ASTM D570
Mold Shrinkage, flow, 24 hrs (2)	0.4	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs (2)	0.5	%	ASTM D955
Mold Shrinkage, flow, 24 hrs (2)	0.43	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (2)	0.51	%	ISO 294
Density	1.27	g/cm³	ISO 1183
INJECTION MOLDING (3)			
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) 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.

(3) 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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