LNP™ THERMOCOMP™ COMPOUND DFZ22P

DF-1004 EP MG

DESCRIPTION

LNP THERMOCOMP DFZ22P compound is based on Polycarbonate (PC) resin containing 10% glass fiber, 10% milled glass. Added features of this grade include: Exceptional Processing.

GENERAL INFORMATION	
Features	High Flow, High stiffness/Strength
Fillers	Glass Fiber, Milled Glass Fiber
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 20260204

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, break	67	MPa	ASTM D638
Tensile Strain, break	6	%	ASTM D638
Tensile Modulus, 50 mm/min	4270	MPa	ASTM D638
Flexural Stress	124	MPa	ASTM D790
Flexural Modulus	3370	MPa	ASTM D790
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 [1]			
Izod Impact, unnotched, 23°C	560	J/m	ASTM D4812
Izod Impact, notched, 23°C	53	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	7	J	ASTM D3763
Multiaxial Impact	8	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	52	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m²	ISO 180/1A
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	132	°C	ASTM D648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	133	°C	ISO 75/Af

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
PHYSICAL [1]			
Moisture Absorption, (23°C/50% RH/24 hrs)	0.1	%	ASTM D570
Mold Shrinkage, flow, 24 hrs [2]	0.4	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs [2]	0.6	%	ASTM D955
Mold Shrinkage, flow, 24 hrs [2]	0.4	%	ISO 294
Mold Shrinkage, xflow, 24 hrs [2]	0.61	%	ISO 294
Density	1.33	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
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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