# LNP™ THERMOCOMP™ COMPOUND DF006ERH

DF-1006 EM MR HC

## DESCRIPTION

LNP THERMOCOMP DF006ERH is a compound based on Polycarbonate resin containing 30% Glass Fiber. Added features of this material include: Healthcare, Easy Molding, Mold Release.

## TYPICAL PROPERTY VALUES

Revision 20231109

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|---|---|---|---|
| MECHANICAL [1] | | | |
| Tensile Stress, brk, Type I, 5 mm/min | 132 | MPa | ASTM D638 |
| Tensile Strain, brk, Type I, 5 mm/min | 2.7 | % | ASTM D638 |
| Tensile Modulus, 5 mm/min | 9500 | MPa | ASTM D638 |
| Flexural Strength, 1.3 mm/min, 50 mm span | 190 | MPa | ASTM D790 |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 8400 | MPa | ASTM D790 |
| Tensile Stress, break, 5 mm/min | 125 | MPa | ISO 527 |
| Tensile Strain, break, 5 mm/min | 2.2 | % | ISO 527 |
| Tensile Modulus, 1 mm/min | 9000 | MPa | ISO 527 |
| Flexural Strength, 2 mm/min | 185 | MPa | ISO 178 |
| Flexural Modulus, 2 mm/min | 7800 | MPa | ISO 178 |
| IMPACT [1] | | | |
| Izod Impact, unnotched, 23°C | 865 | J/m | ASTM D4812 |
| Izod Impact, notched, 23°C | 133 | J/m | ASTM D256 |
| Instrumented Dart Impact Energy @ peak, 23°C | 8 | J | ASTM D3763 |
| Multiaxial Impact | 4 | J | ISO 6603 |
| Izod Impact, unnotched 80*10*4 +23°C | 60 | kJ/m² | ISO 180/1U |
| Izod Impact, notched 80*10*4 +23°C | 13 | kJ/m² | ISO 180/1A |
| THERMAL [1] | | | |
| HDT, 1.82 MPa, 3.2mm, unannealed | 136 | °C | ASTM D648 |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm | 140 | °C | ISO 75/Af |
| PHYSICAL [1] | | | |
| Density | 1.42 | g/cm³ | ASTM D792 |
| Moisture Absorption, (23°C/50% RH/24 hrs) | 0.1 | % | ASTM D570 |
| Mold Shrinkage, flow, 24 hrs [2] | 0.1 | % | ASTM D955 |
| Mold Shrinkage, xflow, 24 hrs [2] | 0.5 | % | ASTM D955 |
| Mold Shrinkage, flow, 24 hrs [2] | 0.11 | % | ISO 294 |
| Mold Shrinkage, xflow, 24 hrs [2] | 0.48 | % | ISO 294 |
| Density | 1.42 | 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 | |

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|---|---|---|---|
| **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.

## DISCLAIMER