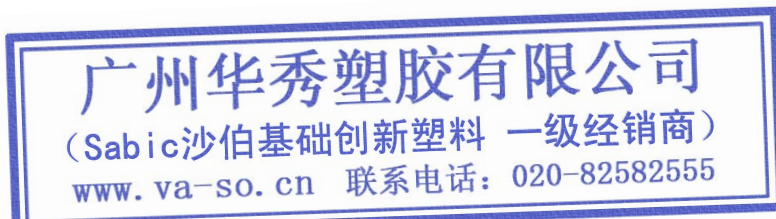


LNP* Colorcomp* Compound D1000FL
Americas: COMMERCIAL

LNP* Colorcomp* D1000FL is an unfilled compound based on Polycarbonate resin. Characteristics of this grade are: Easy Molding and Low Extractible.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	650	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	6	%	ASTM D 638
Tensile Modulus, 50 mm/min	24300	kgf/cm ²	ASTM D 638
THERMAL			
Thermal Conductivity	0.17	W/m-°C	ASTM E 1530
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	125	°C	ISO 75/Af
PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.3	%	ASTM D 570
Density	1.2	g/cm ³	ISO 1183



(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176;C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.
 (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
 (4) Internal measurements according to UL standards.
 (5) 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.

Source GMD, last updated:

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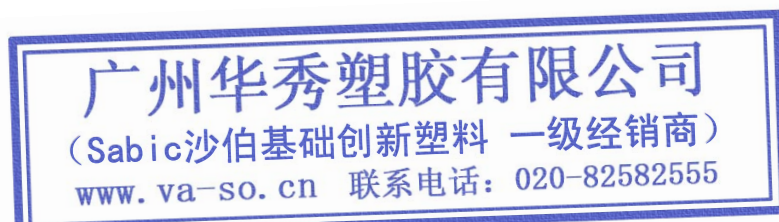
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	305 - 325	°C
Front - Zone 3 Temperature	320 - 330	°C
Middle - Zone 2 Temperature	310 - 320	°C
Rear - Zone 1 Temperature	295 - 305	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm



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