

LNP* Thermocomp* Compound DF004E

Americas: DEVELOPMENTAL

Also known as: DF-1004 EM
Product Reorder Name: DF004E

LNP THERMOCOMP* DF-1004 EM is a compound based on Polycarbonate resin containing Glass Fiber. Added features of this material include: Easy Molding.

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, break	103	MPa	ASTM D 638
Tensile Strain, break	3.1	%	ASTM D 638
Flexural Stress	162	MPa	ASTM D 790
Flexural Modulus	6270	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	640	J/m	ASTM D 4812
Izod Impact, notched, 23°C	80	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	135	°C	ASTM D 648
PHYSICAL			
Density	1.35	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.5	%	ASTM D 955

Source GMD, last updated:09/27/2004

Processing

Parameter	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

Source GMD, last updated:09/27/2004

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(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°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.

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