

# LNPTM COLORCOMPTM COMPOUND D1000P

D-1000 EP

## DESCRIPTION

LNP COLORCOMP D1000P compound is based on unfilled Polycarbonate (PC) resin. Added features of this grade include: Exceptional Processing.

### GENERAL INFORMATION

|                       |                                                                   |
|-----------------------|-------------------------------------------------------------------|
| Features              | High Flow, Aesthetics/Visual effects, No PFAS intentionally added |
| Fillers               | Unreinforced                                                      |
| Polymer Types         | Polycarbonate (PC)                                                |
| Processing Techniques | Injection Molding                                                 |

### INDUSTRY

Automotive  
Consumer  
Electrical and Electronics

### SUB INDUSTRY

Automotive Interiors  
Home Decoration, Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance  
Mobile Phone - Computer - Tablets

## TYPICAL PROPERTY VALUES

Revision 20231109

| PROPERTIES                                 | TYPICAL VALUES | UNITS             | TEST METHODS |
|--------------------------------------------|----------------|-------------------|--------------|
| <strong>MECHANICAL <sup>(1)</sup></strong> |                |                   |              |
| Tensile Stress, yield                      | 62             | MPa               | ASTM D638    |
| Tensile Stress, break                      | 56             | MPa               | ASTM D638    |
| Tensile Strain, yield                      | 5.3            | %                 | ASTM D638    |
| Tensile Strain, break                      | 78.7           | %                 | ASTM D638    |
| Tensile Modulus, 50 mm/min                 | 2060           | MPa               | ASTM D638    |
| Flexural Modulus                           | 2750           | MPa               | ASTM D790    |
| Tensile Stress, yield                      | 64             | MPa               | ISO 527      |
| Tensile Stress, break                      | 59             | MPa               | ISO 527      |
| Tensile Strain, yield                      | 5.6            | %                 | ISO 527      |
| Tensile Strain, break                      | 87             | %                 | ISO 527      |
| Tensile Modulus, 1 mm/min                  | 2210           | MPa               | ISO 527      |
| Flexural Stress                            | 81             | MPa               | ISO 178      |
| Flexural Modulus                           | 2300           | MPa               | ISO 178      |
| <strong>IMPACT <sup>(1)</sup></strong>     |                |                   |              |
| Izod Impact, notched, 23°C                 | 544            | J/m               | ASTM D256    |
| Izod Impact, notched 80*10*4 +23°C         | 13             | kJ/m <sup>2</sup> | ISO 180/1A   |
| <strong>THERMAL <sup>(1)</sup></strong>    |                |                   |              |
| HDT, 1.82 MPa, 3.2mm, unannealed           | 123            | °C                | ASTM D648    |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm      | 124            | °C                | ISO 75/Af    |
| <strong>PHYSICAL <sup>(1)</sup></strong>   |                |                   |              |
| Density                                    | 1.2            | g/cm <sup>3</sup> | ASTM D792    |

| PROPERTIES                                   | TYPICAL VALUES | UNITS             | TEST METHODS |
|----------------------------------------------|----------------|-------------------|--------------|
| Mold Shrinkage, flow, 24 hrs <sup>(2)</sup>  | 0.6 – 0.8      | %                 | ASTM D955    |
| Mold Shrinkage, xflow, 24 hrs <sup>(2)</sup> | 0.7 – 0.9      | %                 | ASTM D955    |
| Mold Shrinkage, flow, 24 hrs <sup>(2)</sup>  | 0.65           | %                 | ISO 294      |
| Mold Shrinkage, xflow, 24 hrs <sup>(2)</sup> | 0.75           | %                 | ISO 294      |
| Density                                      | 1.19           | g/cm <sup>3</sup> | ISO 1183     |
| Melt Flow Rate, 300°C/ 1.2 kgf               | 24             | g/10 min          | ASTM D1238   |
| INJECTION MOLDING <sup>(3)</sup>             |                |                   |              |
| Drying Temperature                           | 120            | °C                |              |
| Drying Time                                  | 4              | Hrs               |              |
| Maximum Moisture Content                     | 0.02           | %                 |              |
| Melt Temperature                             | 300 – 315      | °C                |              |
| Front - Zone 3 Temperature                   | 310 – 320      | °C                |              |
| Middle - Zone 2 Temperature                  | 305 – 315      | °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.

## ADDITIONAL PRODUCT NOTES

No PFAS intentionally added: The grade listed in this document does not contain PFAS intentionally added during Seller's manufacturing process and is not expected to contain unintentional PFAS impurities. Each user is responsible for evaluating the presence of unintentional PFAS impurities.

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