

LNPTTM THERMOCOMPTM 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

Building and Construction
Consumer
Electrical and Electronics
Industrial

SUB INDUSTRY

Building Component
Personal Accessory
Mobile Phone - Computer - Tablets
Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

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/m ²	ISO 180/1U
Izod Impact, notched 80°10°4 +23°C	5	kJ/m ²	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

© 2023 Copyright by SABIC. All rights reserved

CHEMISTRY THAT MATTERS[™]

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/cm ³	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.

DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NON-INFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.