



LNP™ THERMOCOMP™ Compound PCAF04FRHH
Europe-Africa-Middle East: COMMERCIAL

LNP* THERMOCOMP* PCA04FRHH is a 20 % glass reinforced PC+ABS blend without chlorinated or brominated flame retardants. LNP* THERMOCOMP* complies with the material requirements as specified in TCO'99 and Blue Angel ecolabels.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break, 5 mm/min	85	MPa	ISO 527
Tensile Modulus, 1 mm/min	6200	MPa	ISO 527
Flexural Stress, break, 2 mm/min	130	MPa	ISO 178
Flexural Strain, break, 2 mm/min	2.5	%	ISO 178
Flexural Modulus, 2 mm/min	5800	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	23	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/120	130	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	118	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage, flow (5)	0.2 - 0.4	%	SABIC Method
Mold Shrinkage, xflow (5)	0.3 - 0.5	%	SABIC Method
Density	1.32	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 260°C/5.0 kg	8	cm ³ /10 min	ISO 1133
ELECTRICAL			
Comparative Tracking Index	150	V	IEC 60112
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	1.5	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.5 mm	825	°C	IEC 60695-2-13





LNP™ THERMOCOMP™ Compound PCAF04FRHH

Europe-Africa-Middle East: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	230 - 270	°C
Nozzle Temperature	220 - 260	°C
Front - Zone 3 Temperature	230 - 270	°C
Middle - Zone 2 Temperature	220 - 260	°C
Rear - Zone 1 Temperature	200 - 230	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	50 - 70	°C

