

LNP™ THERMOCOMP™ DX05477 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* DX05477 is a compound based on Polycarbonate resin containing Glass Fiber. Added features of this material include: Easy Molding, Mold Release, Flame Retardant.

Also known as: LNP* THERMOCOMP* Compound DFA-113 EM MR

Product reorder name: DX05477

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	Mold Release		
Features	Flame Retardant		
	Good Mold Release		
	Good Moldability		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.50	%	ASTM D955, ISO 294-4
Across Flow : 24 hr	0.60	%	ASTM D955
Across Flow : 24 hr	0.59	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2830	MPa	ASTM D638
--	3600	MPa	ISO 527-2/1
Tensile Strength			
Yield	62.7	MPa	ASTM D638
Yield	70.7	MPa	ISO 527-2
Break	57.2	MPa	ASTM D638
Break	69.4	MPa	ISO 527-2
Tensile Elongation			
Yield	4.2	%	ASTM D638
Yield	3.8	%	ISO 527-2
Break	7.4	%	ASTM D638
Break	4.4	%	ISO 527-2
Flexural Modulus			
--	3450	MPa	ASTM D790
--	3700	MPa	ISO 178
Flexural Strength			

--	120	MPa	ASTM D790
--	121	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	97	J/m	ASTM D256
23°C ²	7.4	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Energy at Peak Load)	5.60	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	145	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	139	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ³	136	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	293 to 304	°C	
Middle Temperature	310 to 321	°C	
Front Temperature	321 to 332	°C	
Processing (Melt) Temp	304 to 327	°C	
Mold Temperature	82.2 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4 mm		

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