

LNP™ THERMOCOMP™ DX06411H compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DX06411H is a compound based on Polycarbonate resin containing 20% Glass Fiber. Added features of this material include: Easy Molding, Mold Release, Healthcare.

Also known as: LNP* THERMOCOMP* Compound DF-1004 EM MR HC

Product reorder name: DX06411H

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Mold Release		
Features	Good Mold Release		
	Good Moldability		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.30 to 0.50	%	
Across Flow : 24 hr	0.50 to 0.70	%	
Water Absorption			
24 hr, 50% RH	0.013	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.018	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6970	MPa	ASTM D638
--	6990	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	104	MPa	ASTM D638
Yield	104	MPa	ISO 527-2/5
Break ³	101	MPa	ASTM D638
Break	102	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	3.2	%	ASTM D638
Yield	3.0	%	ISO 527-2/5
Break ⁵	3.9	%	ASTM D638
Break	3.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	6090	MPa	ASTM D790

-- ⁷	6000	MPa	ISO 178
Flexural Stress			
--	175	MPa	ISO 178
Yield, 50.0 mm Span ⁸	174	MPa	ASTM D790
Break, 50.0 mm Span ⁹	174	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	120	J/m	ASTM D256
23°C ¹⁰	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	950	J/m	ASTM D4812
23°C ¹¹	60	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	18.6	J	ASTM D3763
--	4.96	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	140	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	143	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	136	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	137	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	3.0E-6	cm/cm/°C	
Transverse : -30 to 30°C	7.0E-6	cm/cm/°C	
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.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		

7.	2.0 mm/min
8.	1.3 mm/min
9.	1.3 mm/min
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	80*10*4 mm

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