

LNP™ THERMOCOMP™ NX10302 compound

Polycarbonate + ABS

SABIC Innovative Plastics Asia Pacific

Message:

This is a PC/ABS compound with improved plating, surface and mechanical performance, a good candidate for Laser Direct Structuring applications.

General Information			
UL YellowCard	E207780-101343771		
Features	Platable		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.26	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	14.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.60 to 0.65	%	
Across Flow : 24 hr	0.50 to 0.56	%	
Water Absorption			ASTM D570
24 hr	0.010	%	
24 hr, 50% RH	0.020	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2480	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	46.0	MPa	
Break	47.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	4.2	%	
Break	100	%	
Flexural Modulus ⁴ (50.0 mm Span)	2400	MPa	ASTM D790
Flexural Strength ⁵			ASTM D790
Yield, 50.0 mm Span	80.0	MPa	
Break, 50.0 mm Span	79.0	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	600	J/m	ASTM D256
Unnotched Izod Impact (23°C)	No Break		ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	108	°C	ASTM D648
CLTE			ASTM E831
Flow : -40 to 40°C	8.5E-5	cm/cm/°C	
Transverse : -40 to 40°C	9.1E-5	cm/cm/°C	

Electrical	Nominal Value	Test Method
Relative Permittivity (1.00 GHz)	2.74	IEC 60250
Dissipation Factor (1.00 GHz)	3.0E-3	IEC 60250
Injection	Nominal Value	Unit
Drying Temperature	85.0 to 100	°C
Drying Time	6.0 to 8.0	hr
Rear Temperature	250 to 270	°C
Middle Temperature	250 to 270	°C
Front Temperature	250 to 280	°C
Nozzle Temperature	250 to 290	°C
Processing (Melt) Temp	250 to 290	°C
Mold Temperature	60.0 to 90.0	°C
Back Pressure	0.300 to 0.700	MPa
Screw Speed	40 to 70	rpm
NOTE		
1.	50 mm/min	
2.	Type I, 5.0 mm/min	
3.	Type I, 5.0 mm/min	
4.	1.3 mm/min	
5.	1.3 mm/min	

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