

LNP™ THERMOCOMP™ DX06409 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DX06409 is a compound based on Polycarbonate resin containing 10% Glass Fiber. Added features of this material include: Easy Molding, Mold Release, Healthcare.

Also known as: LNP* THERMOCOMP* Compound DF-1002 EM MR HC

Product reorder name: DX06409

General Information			
Filler / Reinforcement	Glass Fiber,10% 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			
--	1.28	g/cm ³	ASTM D792
--	1.27	g/cm ³	ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.40	%	ASTM D955
Across Flow : 24 hr	0.50	%	ASTM D955
Across Flow : 24 hr	0.51	%	ISO 294-4
Flow : 24 hr	0.43	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4170	MPa	ASTM D638
--	4100	MPa	ISO 527-2/1
Tensile Strength			
Break	83.4	MPa	ASTM D638
Break	84.0	MPa	ISO 527-2
Tensile Elongation			
Break	3.8	%	ASTM D638
Break	3.6	%	ISO 527-2
Flexural Modulus			
--	4280	MPa	ASTM D790
--	3920	MPa	ISO 178
Flexural Strength			

--	145	MPa	ASTM D790
--	117	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	96	J/m	ASTM D256
23°C ²	8.7	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	910	J/m	ASTM D4812
23°C ³	62	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	13.0	J	ASTM D3763
--	9.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	141	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	141	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	137	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	137	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	3.8E-5	cm/cm/°C	
Transverse : -40 to 40°C	5.4E-5	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.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		
5.	80*10*4 mm		

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