

LNP™ THERMOCOMP™ NX11302 compound

Polycarbonate + ABS

SABIC Innovative Plastics Asia Pacific

Message:

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

General Information			
UL YellowCard	E207780-100974177		
Features	Good Colorability		
	Good Surface Finish		
	Platable		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.22	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	%	
Across Flow : 24 hr	0.60	%	
Water Absorption			ASTM D570
24 hr	0.010	%	
24 hr, 50% RH	0.010	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2350	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	47.0	MPa	
Break	46.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	4.6	%	
Break	75	%	
Flexural Modulus ⁴ (50.0 mm Span)	2230	MPa	ASTM D790
Flexural Strength ⁵			ASTM D790
Yield, 50.0 mm Span	79.0	MPa	
Break, 50.0 mm Span	78.0	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	550	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	106	°C	ASTM D648
CLTE			ASTM E831

Flow : -40 to 40°C	7.1E-5	cm/cm/°C
Transverse : -40 to 40°C	7.6E-5	cm/cm/°C
Electrical	Nominal Value	Test Method
Relative Permittivity (1.00 GHz)	2.94	IEC 60250
Dissipation Factor (1.00 GHz)	5.7E-3	IEC 60250
Injection	Nominal Value	Unit
Drying Temperature	85.0 to 96.1	°C
Drying Time	2.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Max Moisture	0.010	%
Suggested Shot Size	50 to 70	%
Rear Temperature	199 to 249	°C
Middle Temperature	216 to 254	°C
Front Temperature	216 to 254	°C
Nozzle Temperature	218 to 260	°C
Processing (Melt) Temp	218 to 260	°C
Mold Temperature	37.8 to 76.7	°C
Back Pressure	0.517 to 0.862	MPa
Screw Speed	50 to 100	rpm
Vent Depth	0.038 to 0.051	mm
NOTE		
1.	50 mm/min	
2.	Type I, 50 mm/min	
3.	Type I, 50 mm/min	
4.	1.3 mm/min	
5.	1.3 mm/min	

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