

LNP™ THERMOCOMP™ DX09309 compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LNP* THERMOCOMP* DX09309 is a mineral filled polycarbonate compound with high dielectric constant.

General Information			
Filler / Reinforcement	Mineral		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	2.23	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (280°C/2.16 kg)	20.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.65	%	
Across Flow : 3.20 mm	0.56	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	27.0	MPa	ASTM D638
Tensile Elongation ² (Break)	4.2	%	ASTM D638
Flexural Modulus	2490	MPa	ASTM D790
Flexural Strength	60.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	68	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	94.0	°C	ASTM D648
CLTE			ASTM E831
Flow : -40 to 40°C	6.2E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.4E-5	cm/cm/°C	
Electrical	Nominal Value		Test Method
Dielectric Constant (1.10 GHz)	8.00		Internal Method
Dissipation Factor (1.10 GHz)	0.010		Internal Method
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 110	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	250 to 280	°C	
Middle Temperature	280 to 320	°C	
Front Temperature	280 to 320	°C	
Nozzle Temperature	280 to 320	°C	
Processing (Melt) Temp	280 to 320	°C	
Mold Temperature	90.0 to 120	°C	

Back Pressure	1.00 to 5.00	MPa
Screw Speed	30 to 100	rpm
NOTE		
1.	Type I, 5.0 mm/min	
2.	Type I, 5.0 mm/min	

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