

LNP™ THERMOCOMP™ DX06410 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DX06410 is a compound based on Polycarbonate resin containing 20% Glass Fiber. Added features of this material include: Easy Molding, Mold Release.

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

Product reorder name: DX06410

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Mold Release		
Features	Good Mold Release		
	Good Moldability		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792
Molding Shrinkage - Flow (24 hr)	0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	6490	MPa	ASTM D638
Tensile Strength (Break)	112	MPa	ASTM D638
Tensile Elongation (Break)	3.1	%	ASTM D638
Flexural Modulus	6210	MPa	ASTM D790
Flexural Strength	172	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	130	J/m	ASTM D256
Unnotched Izod Impact (23°C)	900	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	139	°C	ASTM D648
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	

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Recommended distributors for this material

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