

LNP™ THERMOCOMP™ DX10311X compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

DX10311X is 30% glass fiber reinforced, impact modified polycarbonate resin. High flow and good ductility.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Impact Modifier		
Features	Ductile		
	High Flow		
	Impact Modified		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (300°C/2.16 kg)	9.00	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.10 to 0.40	%	
Across Flow : 3.20 mm	0.20 to 0.50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	8690	MPa	ASTM D638
--	8610	MPa	ISO 527-2/1
Tensile Strength			
Break ²	114	MPa	ASTM D638
Break	115	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.5	%	ASTM D638
Break	2.5	%	ISO 527-2/5
Flexural Modulus			
--	7410	MPa	ASTM D790
-- ⁴	7450	MPa	ISO 178
Flexural Strength			
--	180	MPa	ASTM D790
--	180	MPa	ISO 178
--	172	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	17	kJ/m ²	ISO 179/2C

Charpy Unnotched Impact Strength (23°C)	45	kJ/m ²	ISO 179/2U
Notched Izod Impact (23°C)	170	J/m	ASTM D256
Unnotched Izod Impact (23°C)	720	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 3.20 mm)	125	°C	ASTM D648
CLTE			ASTM E831
Flow : -40 to 40°C	2.1E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.8E-5	cm/cm/°C	
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.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	2.0 mm/min		

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