

LNP™ THERMOCOMP™ DF002FV compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LNP* Thermocomp* DX13354 compound is a 10% glass fiber reinforced, impact modified PC resin based LDS material solution with stable plating and RF performance. Good surface aesthetics and wide processing window makes it a good candidate for internal and external parts for Laser Direct Structuring applications.

General Information			
UL YellowCard	E207780-102822332		
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Additive	Impact modifier		
Features	Impact modification		
	Electroplateable		
	Excellent appearance		
Uses	Laser Direct Structuring		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	29	g/10 min	ASTM D1238
Molding Shrinkage			Internal method
Flow: 3.20mm	0.30	%	Internal method
Transverse flow: 3.20mm	0.50	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3800	MPa	ASTM D638
Tensile Stress (Break)	60.0	MPa	ISO 527-2/5
Tensile Elongation ² (Break)	4.1	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	3600	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	110	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	170	J/m	ASTM D256
Unnotched Izod Impact (23°C)	700	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	125	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	119	°C	ASTM D648
Electrical	Nominal Value		Test Method
Dielectric Constant			Internal method
1.10 GHz	3.05		Internal method
1.90 GHz	3.05		Internal method

5.00 GHz	3.04	Internal method
Dissipation Factor		Internal method
1.10 GHz	0.014	Internal method
1.90 GHz	0.013	Internal method
5.00 GHz	0.011	Internal method

Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	3.0 - 4.0	hr
Rear Temperature	270 - 295	°C
Middle Temperature	270 - 295	°C
Front Temperature	270 - 295	°C
Nozzle Temperature	270 - 295	°C
Processing (Melt) Temp	270 - 295	°C
Mold Temperature	100 - 120	°C

NOTE		
1.	5.0 mm/min	
2.	Type 1, 5.0 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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