

LNP™ THERMOCOMP™ DX07350 compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LEXAN® DX07350 resin is a glass filled, Non-brominated & Non-chlorinated flame retardant polycarbonate. High stiffness and good flow.

General Information			
UL YellowCard	E207780-101358100		
Filler / Reinforcement	Glass Fiber		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
	Good Flow		
	High Stiffness		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.29	g/cm ³	ASTM D792, ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/2.16 kg)	21.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.35 to 0.45	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.090	%	
Equilibrium, 23°C, 50% RH	0.050	%	
Hardness	Nominal Value	Unit	Test Method
Pencil Hardness			ASTM D3363
-- ¹	F		
-- ²	HB		
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ³	4700	MPa	ASTM D638
--	4800	MPa	ISO 527-2/1
Tensile Strength			
Yield ⁴	65.0	MPa	ASTM D638
Yield	68.0	MPa	ISO 527-2/5
Break ⁵	55.0	MPa	ASTM D638
Break	54.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁶	4.0	%	ASTM D638
Yield	3.8	%	ISO 527-2/5

Break ⁷	5.0	%	ASTM D638
Break	4.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁸	4200	MPa	ASTM D790
-- ⁹	4600	MPa	ISO 178
Flexural Stress			
--	120	MPa	ISO 178
Yield, 50.0 mm Span ¹⁰	116	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹¹			ISO 179/1eA
-30°C	3.3	kJ/m ²	
23°C	3.5	kJ/m ²	
Charpy Unnotched Impact Strength ¹²			ISO 179/1eU
-30°C	61	kJ/m ²	
23°C	75	kJ/m ²	
Notched Izod Impact			
-30°C	35	J/m	ASTM D256
23°C	42	J/m	ASTM D256
-30°C ¹³	4.6	kJ/m ²	ISO 180/1A
23°C ¹⁴	4.7	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ¹⁵			ISO 180/1U
-30°C	47	kJ/m ²	
23°C	50	kJ/m ²	
Instrumented Dart Impact (23°C, Total Energy)	11.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	102	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁶	104	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	112	°C	ASTM D1525, ISO 306/B120 13 ¹⁷
--	109	°C	ISO 306/B50
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	3.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.6E-5	cm/cm/°C	
Flammability	Nominal Value		Test Method
Flame Rating (0.800 mm, Testing by SABIC)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 to 80.0	°C	

Rear Temperature	250 to 280	°C
Middle Temperature	260 to 290	°C
Front Temperature	270 to 300	°C
Nozzle Temperature	270 to 290	°C
Processing (Melt) Temp	270 to 300	°C
Mold Temperature	60.0 to 100	°C

NOTE

1.	0.5 kgf
2.	1 kgf
3.	5.0 mm/min
4.	Type I, 5.0 mm/min
5.	Type I, 5.0 mm/min
6.	Type I, 5.0 mm/min
7.	Type I, 5.0 mm/min
8.	1.3 mm/min
9.	2.0 mm/min
10.	1.3 mm/min
11.	80*10*3 sp=62mm
12.	80*10*3 sp=62mm
13.	80*10*3
14.	80*10*3
15.	80*10*3
16.	80*10*4 mm
17.	Rate B (120°C/h), Loading 2 (50 N)

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