

LNP™ THERMOCOMP™ DX11354 compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

This is a PC compound with good plating, surface and mechanical performance, a good candidate for Laser Direct Structuring applications.

General Information			
UL YellowCard	E207780-101230645		
Features	Good Surface Finish		
	Platable		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.60 to 0.65	%	
Across Flow : 24 hr	0.60 to 0.65	%	
Water Absorption (24 hr, 50% RH)	0.010	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2560	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	59.0	MPa	
Break	52.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	5.7	%	
Break	64	%	
Flexural Modulus ⁴ (50.0 mm Span)	2300	MPa	ASTM D790
Flexural Strength ⁵			ASTM D790
Yield, 50.0 mm Span	91.0	MPa	
Break, 50.0 mm Span	90.0	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	750	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	124	°C	ASTM D648
CLTE			ASTM E831
Flow : -40 to 40°C	6.3E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.9E-5	cm/cm/°C	
Electrical	Nominal Value		Test Method

Relative Permittivity (1.00 GHz)	2.92	IEC 60250
Dissipation Factor (1.00 GHz)	7.0E-3	IEC 60250
Flammability	Nominal Value	Test Method
Flame Rating (0.600 mm, Testing by SABIC)	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	100 to 110	°C
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	30 to 80	%
Hopper Temperature	60.0 to 80.0	°C
Rear Temperature	250 to 290	°C
Middle Temperature	255 to 295	°C
Front Temperature	260 to 300	°C
Nozzle Temperature	275 to 300	°C
Processing (Melt) Temp	275 to 300	°C
Mold Temperature	60.0 to 90.0	°C
Back Pressure	0.300 to 0.700	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.038 to 0.076	mm
NOTE		
1.	50 mm/min	
2.	Type I, 50 mm/min	
3.	Type I, 50 mm/min	
4.	1.3 mm/min	
5.	1.3 mm/min	

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

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

