

LNP* Thermocomp* Compound DX06408

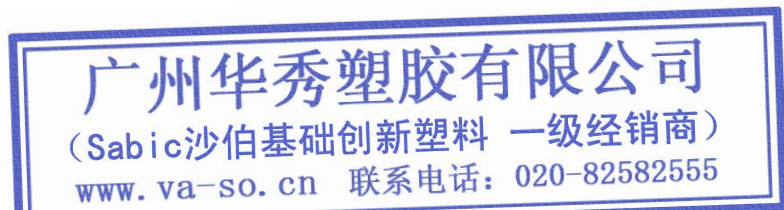
Americas: COMMERCIAL

Also known as: LNP* Thermocomp* Compound DF-1002 EM MR BE

Product reorder name: DX06408

LNP THERMOCOMP* DX06408 is a compound based on Polycarbonate resin containing Glass Fiber. Added features of this material include: Easy Molding.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	850	kgf/cm ²	ASTM D 638
Tensile Strain, break	3.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	42500	kgf/cm ²	ASTM D 638
Flexural Stress	1520	kgf/cm ²	ASTM D 790
Flexural Modulus	43600	kgf/cm ²	ASTM D 790
Tensile Stress, break	84	MPa	ISO 527
Tensile Strain, break	3.6	%	ISO 527
Tensile Modulus, 1 mm/min	4100	MPa	ISO 527
Flexural Stress	117	MPa	ISO 178
Flexural Modulus	3920	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	94	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	9	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	136	cm-kgf	ASTM D 3763
Multiaxial Impact	94	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	61	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	141	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	136	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.81E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.34E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	3.82E-05	1/°C	ISO 11359-2



(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176.C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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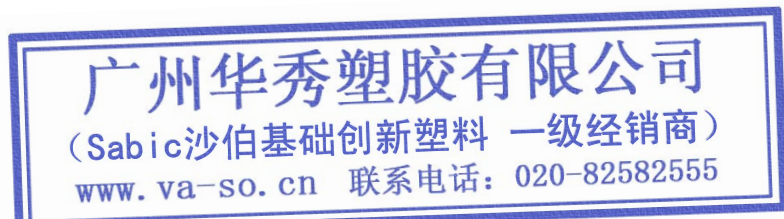
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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
CTE, -40°C to 40°C, xflow	5.35E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	137	°C	ISO 75/Af
PHYSICAL			
Density	1.275	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.15	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.5	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.43	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.51	%	ISO 294
Density	1.27	g/cm ³	ISO 1183



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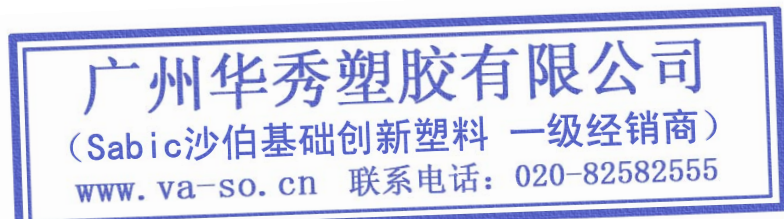
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	305 - 325	°C
Front - Zone 3 Temperature	320 - 330	°C
Middle - Zone 2 Temperature	310 - 320	°C
Rear - Zone 1 Temperature	295 - 305	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm



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