LNP™ COLORCOMP™ COMPOUND DX18272

DESCRIPTION

Ophthalmic/safety lens market. DX18272 series in all transparent tints. Dedicated equipment, stringent quality production control.

TYPICAL PROPERTY VALUES

Revision 20191217

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	68	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	135	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	96	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	907	J/m	ASTM D 256
Tensile Impact Strength, Type S	604	kJ/m²	ASTM D 1822
Instrumented Impact Energy @ peak, 23°C	65	J	ASTM D 3763
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	132	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/1.2 kgf	7.5	g/10 min	ASTM D 1238
OPTICAL			
Light Transmission, 2.54 mm	89	%	ASTM D 1003
Haze, 2.54 mm	0.6	%	ASTM D 1003
Refractive Index	1.586	-	ASTM D542
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	310 – 330	°C	
Nozzle Temperature	305 – 325	°C	
Front - Zone 3 Temperature	310 – 330	°C	
Middle - Zone 2 Temperature	300 – 320	°C	
Rear - Zone 1 Temperature	290 – 310	°C	
Mold Temperature	80 – 115	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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