LNP™ COLORCOMP™ COMPOUND DX06407H

D-1000 EM MR HC

DESCRIPTION

LNP COLORCOMP DX06407H is an unfilled Polycarbonate. Added features of this material include: Easy Molding, Mold Release, Healthcare

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	63	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	58	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	6.2	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	94	%	ASTM D 638
Tensile Modulus, 5 mm/min	2340	MPa	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span	2400	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	65	MPa	ISO 527
Tensile Stress, break, 5 mm/min	54	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	6.3	%	ISO 527
Tensile Strain, break, 5 mm/min	104	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress	91	MPa	ISO 178
Flexural Modulus, 2 mm/min	2290	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1310	J/m	ASTM D 4812
Izod Impact, notched, 23°C	781	J/m	ASTM D 256
Multiaxial Impact	69	J	ISO 6603
Instrumented Impact Total Energy, 23°C	63	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	224	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	9	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	94	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	103	°C	ASTM D 648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	96	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	104	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Density	1.2	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.7 – 0.9	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.02	%	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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