LNP™ COLORCOMP™ COMPOUND DX99340H

PDX-D-99340

DESCRIPTION

LNP COLORCOMP DX99340H is an unfilled Polycarbonate resin. Added feature of this grade is: Healthcare.

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
IMPACT			
Izod Impact, notched, 23°C	694	J/m	ASTM D 256
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Melt Flow Rate, 300°C/1.2 kgf	23.8	g/10 min	ASTM D 1238
Melt Volume Rate, MVR at 300°C/1.2 kg	23	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 305	°C	
Nozzle Temperature	275 – 300	°C	
Front - Zone 3 Temperature	280 – 305	°C	
Middle - Zone 2 Temperature	270 – 295	°C	
Rear - Zone 1 Temperature	260 – 280	°C	
Mold Temperature	70 – 95	°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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