LNP™ THERMOCOMP™ COMPOUND DF006LXN

DF006LXN

DESCRIPTION

LNP THERMOCOMP DF006LXN is a compound based on Polycarbonate resin containing 30% Glass Fiber. Added features of this material are: Low Extractable.

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	114	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	8630	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	149	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	8230	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	114	MPa	ISO 527
Tensile Strain, break, 5 mm/min	7.5	%	ISO 527
Flexural Stress	185	MPa	ISO 178
Flexural Modulus, 2 mm/min	7860	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	914	J/m	ASTM D 4812
Izod Impact, notched, 23°C	144	J/m	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	56	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	144	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	140	°C	ASTM D 648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	145	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.45	-	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.07	%	ASTM D 570
Density	1.45	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.07	%	ISO 62
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	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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