LNP™ THERMOCOMP™ COMPOUND DX10311X

DESCRIPTION

DX10311X is 30% glass fiber reinforced, impact modified polycarbonate resin. High flow and good ductility.

TYPICAL PROPERTY VALUES

Revision 20191216

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	114	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Modulus, 5 mm/min	8690	MPa	ASTM D 638
Flexural Stress	180	MPa	ASTM D 790
Flexural Modulus	7410	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	115	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.5	%	ISO 527
Tensile Modulus, 1 mm/min	8610	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	172	MPa	ISO 178
Flexural Stress, break, 2 mm/min	180	MPa	ISO 178
Flexural Modulus, 2 mm/min	7450	MPa	ISO 178
IMPACT			
Charpy Impact, unnotched, 23°C	45	kJ/m²	ISO 179/2C
Izod Impact, unnotched, 23°C	715	J/m	ASTM D 4812
Izod Impact, notched, 23°C	165	J/m	ASTM D 256
Charpy Impact, notched, 23°C	17	kJ/m²	ISO 179/2C
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	125	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.1E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.8E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.43	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.1 – 0.4	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.2 – 0.5	%	SABIC method
Melt Volume Rate, MVR at 300°C/2.16 kg	9	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	90 – 110	°C	
Drying Time	3 – 5	hrs	
Melt Temperature	280 – 320	°C	
Nozzle Temperature	280 – 320	°C	
Front - Zone 3 Temperature	280 – 320	°C	
Middle - Zone 2 Temperature	280 – 320	°C	
Rear - Zone 1 Temperature	250 – 280	°C	
Mold Temperature	90 – 120	°C	
Back Pressure	1 – 5	MPa	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Screw Speed	30 – 100	rpm	

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