LNP™ THERMOCOMP™ COMPOUND DX05477

DFA-113 EM MR

DESCRIPTION

LNP THERMOCOMP* DX05477 is a compound based on Polycarbonate resin containing Glass Fiber. Added features of this material include: Easy Molding, Mold Release, Flame Retardant.

TYPICAL PROPERTY VALUES

Revision 20200129

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	62	MPa	ASTM D 638
Tensile Stress, break	57	MPa	ASTM D 638
Tensile Strain, yield	4.2	%	ASTM D 638
Tensile Strain, break	7.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	2820	MPa	ASTM D 638
Flexural Stress	119	MPa	ASTM D 790
Flexural Modulus	3440	MPa	ASTM D 790
Tensile Stress, yield	70	MPa	ISO 527
Tensile Stress, break	69	MPa	ISO 527
Tensile Strain, yield	3.8	%	ISO 527
Tensile Strain, break	4.4	%	ISO 527
Tensile Modulus, 1 mm/min	3600	MPa	ISO 527
Flexural Stress	120	MPa	ISO 178
Flexural Modulus	3700	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	96	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	5	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	145	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	136	°C	ISO 75/Af
PHYSICAL			
Density	1.271	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.6	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.5	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.59	%	ISO 294
Density	1.26	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	305 – 325	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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