LNP™ STAT-KON™ COMPOUND DX10315C

DESCRIPTION

LNP STAT-KON DX10315C is carbon fiber filled polycarbonate composite with good stiffness, good flow ability, ESD safety, and high level of cleanliness for the most demanding application. This compound is manufactured using LNP CCS Technology.

TYPICAL PROPERTY VALUES

Revision 20191212

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	140	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.7	%	ASTM D 638
Tensile Modulus, 5 mm/min	10810	MPa	ASTM D 638
Flexural Stress	211	MPa	ASTM D 790
Flexural Modulus	9040	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	588	J/m	ASTM D 4812
Izod Impact, notched, 23°C	77	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.26	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.1 – 0.3	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.1 – 0.3	%	SABIC method
Melt Volume Rate, MVR at 300°C/5.0 kg	31	cm³/10 min	ISO 1133
ELECTRICAL			
Surface Resistivity	1.E+03 – 1.E+05	Ohm	ASTM D 257
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	
Screw Speed	30 – 100	rpm	

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