

LNP™ THERMOCOMP™ COMPOUND DX05475

DFA-113
REGION AMERICAS

DESCRIPTION

LNP THERMOCOMP DX05474 is a compound based on Polycarbonate resin containing Glass Fiber. Added features of this material include: Flame Retardant.

TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	59	MPa	ASTM D 638
Tensile Stress, break	54	MPa	ASTM D 638
Tensile Strain, yield	4.9	%	ASTM D 638
Tensile Strain, break	8.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	3590	MPa	ASTM D 638
Flexural Stress	103	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	1068	J/m	ASTM D 4812
Izod Impact, notched, 23°C	58	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	132	°C	ASTM D 648
PHYSICAL			
Density	1.29	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.3 – 0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.3 – 0.4	%	ASTM D 955
MECHANICAL PROPERTIES			
Flexural modulus	3610	MPa	ISO 178/1A
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	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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