

LNPTM COLORCOMPTM COMPOUND DX99340H

PDX-D-99340

DESCRIPTION

LNP COLORCOMP DX99340H compound is based on Polycarbonate (PC) resin. Added features of this grade include: Healthcare.

GENERAL INFORMATION

Features	Aesthetics/Visual effects, Healthcare/Formula lock
Fillers	Unreinforced
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY

Hygiene and Healthcare
Packaging

SUB INDUSTRY

Pharmaceutical Packaging and Drug Delivery, Surgical devices, General Healthcare, Patient Testing
Industrial Packaging

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
IMPACT ⁽¹⁾			
Izod Impact, notched, 23°C	694	J/m	ASTM D256
PHYSICAL ⁽¹⁾			
Specific Gravity	1.21	-	ASTM D792
Melt Flow Rate, 300°C/ 1.2 kgf	23.8	g/ 10 min	ASTM D1238
Melt Volume Rate, MVR at 300°C/1.2 kg	23	cm ³ / 10 min	ISO 1133
INJECTION MOLDING ⁽²⁾			
Drying Temperature	120	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	48	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 305	°C	
Nozzle Temperature	275 – 300	°C	
Front - Zone 3 Temperature	280 – 305	°C	
Middle - Zone 2 Temperature	270 – 295	°C	
Rear - Zone 1 Temperature	260 – 280	°C	
Mold Temperature	70 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	



- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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