

LNPTTM THERMOCOMPTM COMPOUND DC006ERH

DC-1006 EM MR HC

DESCRIPTION

LNP THERMOCOMP DC006ERH compound is based on Polycarbonate (PC) resin containing 30% carbon fiber. Added features of this grade include: Electrically Conductive, Easy Molding, Mold Release, Healthcare.

GENERAL INFORMATION

Features	Electrically Conductive, Good Processability, Healthcare/Formula lock, Enhanced mold release, Carbon fiber filled, High stiffness/Strength, No PFAS intentionally added
Fillers	Carbon Fiber
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
MECHANICAL ⁽¹⁾			
Tensile Stress, brk, Type I, 5 mm/min	158	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	1.7	%	ASTM D638
Tensile Modulus, 5 mm/min	18620	MPa	ASTM D638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	234	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	15600	MPa	ASTM D790
Tensile Stress, break, 5 mm/min	156	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.6	%	ISO 527
Tensile Modulus, 1 mm/min	18060	MPa	ISO 527
Flexural Stress	224	MPa	ISO 178
Flexural Modulus, 2 mm/min	16110	MPa	ISO 178
IMPACT ⁽¹⁾			
Izod Impact, unnotched, 23°C	609	J/m	ASTM D4812
Izod Impact, notched, 23°C	75	J/m	ASTM D256
Multiaxial Impact	3	J	ISO 6603
Instrumented Dart Impact Total Energy, 23°C	11	J	ASTM D3763
Izod Impact, unnotched 80°10°4 +23°C	35	kJ/m ²	ISO 180/1U
Izod Impact, notched 80°10°4 +23°C	8	kJ/m ²	ISO 180/1A
THERMAL ⁽¹⁾			
HDT, 0.45 MPa, 3.2 mm, unannealed	146	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	140	°C	ASTM D648
CTE, -30°C to 30°C, flow	1.2E-05	1/°C	ASTM D696

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -30°C to 30°C, xflow	3.7E-05	1 / °C	ASTM D696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	146	°C	ISO 75 /Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75 /Af
PHYSICAL ⁽¹⁾			
Specific Gravity	1.32	-	ASTM D792
Density	1.32	g / cm ³	ASTM D792
Moisture Absorption, (23°C / 50% RH / 24 hrs)	0.1	%	ASTM D570
Mold Shrinkage, flow, 24 hrs ⁽²⁾	0.23	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs ⁽²⁾	0.49	%	ASTM D955
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
INJECTION MOLDING ⁽³⁾			
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	
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	

(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) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(3) 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.

ADDITIONAL PRODUCT NOTES

No PFAS intentionally added: The grade listed in this document does not contain PFAS intentionally added during Seller's manufacturing process and is not expected to contain unintentional PFAS impurities. Each user is responsible for evaluating the presence of unintentional PFAS impurities.

DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NON-INFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.