LNP™ THERMOCOMP™ COMPOUND DF006LXN

DF006LXN

DESCRIPTION

LNP THERMOCOMP DF006LXN compound is based on Polycarbonate (PC) resin containing 30% glass fiber. Added features of this grade include: Low Extractables.

GENERAL INFORMATION	
Features	Food contact, High stiffness/Strength
Fillers	Glass Fiber
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component
Consumer	Personal Accessory
Electrical and Electronics	Mobile Phone - Computer - Tablets
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, brk, Type I, 5 mm/min	114	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	2.7	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	3.2	%	ASTM D638
Tensile Modulus, 50 mm/min	8630	MPa	ASTM D638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	149	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	8230	MPa	ASTM D790
Tensile Stress, break, 5 mm/min	114	MPa	ISO 527
Tensile Strain, break, 5 mm/min	7.5	%	ISO 527
Flexural Stress	185	MPa	ISO 178
Flexural Modulus, 2 mm/min	7860	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched, 23°C	914	J/m	ASTM D4812
Izod Impact, notched, 23°C	144	J/m	ASTM D256
Izod Impact, unnotched 80*10*4 +23°C	56	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m²	ISO 180/1A
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	144	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	140	°C	ASTM D648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	145	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Af

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
PHYSICAL (1)			
Specific Gravity	1.45	-	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.07	%	ASTM D570
Density	1.45	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.07	%	ISO 62
INJECTION MOLDING (2)			
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) 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.

DISCLAIMER

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