

Product Texts

LNP THERMOCOMP DX05477 compound is based on Polycarbonate (PC) resin containing 10% glass fiber. Added features of this grade include: Easy Molding, Mold Release, Flame Retardant.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	0.5	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.6	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3600	MPa	ISO 527
Yield stress	70	MPa	ISO 527
Yield strain	3.8	%	ISO 527
Stress at break	69	MPa	ISO 527
Strain at break	4.4	%	ISO 527
Flexural modulus	3700	MPa	ISO 178
Flexural strength	120	MPa	ISO 178
Izod notched impact strength, +23°C, 4mm	7	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	2820	MPa	ASTM D 638
Tensile Strength at Yield	62	MPa	ASTM D 638
Tensile Strength at Break	57	MPa	ASTM D 638
Elongation at Yield	4.2	%	ASTM D 638
Elongation at Break	7.4	%	ASTM D 638
Flexural Modulus	3440	MPa	ASTM D 790
Flexural Strength	119	MPa	ASTM D 790
Izod Impact notched, 1/8 in	96	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	136	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 66 psi	145	°C	ASTM D 648
DTUL @ 264 psi	138	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1260	kg/m ³	ISO 1183
Density	1270	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	305 - 325	°C	-
Mold temperature	80 - 110	°C	-
Zone 1	295 - 305	°C	-
Zone 2	310 - 320	°C	-
Zone 3	320 - 330	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.2 - 0.3	MPa	-

Characteristics

Processing

Injection Molding

Additives

Flame retarding agent

Special Characteristics

Flame retardant

Regional Availability

North America, Europe, Asia Pacific