

Product Texts

LNP THERMOCOMP DX06409 compound is based on Polycarbonate (PC) resin containing 10% glass fiber. Added features of this grade include: Easy Molding, Mold Release, Low Extractables, Healthcare.

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|--|--------------|-------------|----------------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 0.4 | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | 0.5 | % | ISO 294-4, 2577 |
| ASTM Data | | | |
| Mold Shrinkage, MD | 0.4 | mm/mm | ASTM D 955 |
| Mold Shrinkage, TD | 0.5 | mm/mm | ASTM D 955 |

| Mechanical properties | Value | Unit | Test Standard |
|--|--------------|-------------------|----------------------|
| ISO Data | | | |
| Tensile Modulus | 4100 | MPa | ISO 527 |
| Stress at break | 84 | MPa | ISO 527 |
| Strain at break | 3.6 | % | ISO 527 |
| Flexural modulus | 3920 | MPa | ISO 178 |
| Flexural strength | 117 | MPa | ISO 178 |
| Izod impact strength, +23°C, 4mm | 61 | kJ/m ² | ISO 180/1U |
| Izod notched impact strength, +23°C, 4mm | 8 | kJ/m ² | ISO 180/1A |
| ASTM Data | | | |
| Tensile Modulus | 4170 | MPa | ASTM D 638 |
| Tensile Strength at Break | 83 | MPa | ASTM D 638 |
| Elongation at Break | 3.8 | % | ASTM D 638 |
| Flexural Modulus | 4280 | MPa | ASTM D 790 |
| Flexural Strength | 144 | MPa | ASTM D 790 |
| Izod Impact notched, 1/8 in | 96 | J/m | ASTM D 256 |
| Izod Impact unnotched, 1/8 in | 907 | J/m | ASTM D 256 |

| Thermal properties | Value | Unit | Test Standard |
|--|--------------|-------------|----------------------|
| ISO Data | | | |
| Temp. of deflection under load, 1.80 MPa | 137 | °C | ISO 75-1/-2 |
| Temp. of deflection under load, 0.45 MPa | 141 | °C | ISO 75-1/-2 |
| ASTM Data | | | |
| DTUL @ 66 psi | 141 | °C | ASTM D 648 |
| DTUL @ 264 psi | 136 | °C | ASTM D 648 |

| Other properties | Value | Unit | Test Standard |
|-------------------------|--------------|-------------------|----------------------|
| Density | 1270 | kg/m ³ | ISO 1183 |
| Water Absorption, 24hr | 0.1 | % | ASTM D 570 |
| Density | 1280 | 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

Regional Availability

North America, Europe, Asia Pacific