

**Product Texts**

LNP THERMOCOMP DX06411H compound is based on Polycarbonate (PC) resin containing 20% glass fiber. Added features of this grade include: Easy Molding, Mold Release, Healthcare.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.4	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.6	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	6990	MPa	ISO 527
Yield stress	104	MPa	ISO 527
Yield strain	2.9	%	ISO 527
Stress at break	102	MPa	ISO 527
Strain at break	3.8	%	ISO 527
Flexural modulus	6000	MPa	ISO 178
Flexural strength	175	MPa	ISO 178
Izod impact strength, +23°C, 4mm	59	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	11	kJ/m <sup>2</sup>	ISO 180/1A

<b>ASTM Data</b>			
Tensile Modulus	6960	MPa	ASTM D 638
Tensile Strength at Yield	104	MPa	ASTM D 638
Tensile Strength at Break	101	MPa	ASTM D 638
Elongation at Yield	3.1	%	ASTM D 638
Elongation at Break	3.9	%	ASTM D 638
Flexural Modulus	6090	MPa	ASTM D 790
Izod Impact notched, 1/8 in	118	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	947	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	137	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	143	°C	ISO 75-1/-2
<b>ASTM Data</b>			
Coefficient of Thermal Expansion, MD	3.01	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	7	E-6/K	ASTM D 696
DTUL @ 66 psi	140	°C	ASTM D 648
DTUL @ 264 psi	136	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Humidity absorption	0.01	%	Sim. to ISO 62
Water Absorption, 24hr	0.01	%	ASTM D 570
Density	1350	kg/m <sup>3</sup>	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