XANTAR™ LDS 3720

(PC+ABS) Mitsubishi Engineering-Plastics Corporation

Product Texts

Vicat 122°C, Black color only, Improved Impact, Halogen free, Laser Direct Structuring (LDS) *

ISO 1043 (PC+ABS)

XANTAR Polycarbonate & Blends, your global partner for innovative added value

**The compound is intended specifically for the use in the process of manufacturing conducting path designs according to the German application of the patent 101 32 092 of LPKF Laser & Electronics AG (Osteriede 7 30827 Garbsen Germany). Please address straight to LPKF Laser & Electronics AG (www.LPKF.de).*

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
[C] Melt volume-flow rate, MVR	**13**	cm³/10min	ISO 1133
Temperature	**260**	°C	-
Load	**5**	kg	-
[C] Molding shrinkage, parallel	**0.5**	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**2250**	MPa	ISO 527
[C] Yield stress	**51**	MPa	ISO 527
[C] Yield strain	**4**	%	ISO 527
[C] Nominal strain at break	**>50**	%	ISO 527
[C] Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
[C] Charpy impact strength, -30°C	**N**	kJ/m²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	**60**	kJ/m²	ISO 179/1eA
[C] Charpy notched impact strength, -30°C	**25**	kJ/m²	ISO 179/1eA
[C] Puncture energy, +23°C	**35**	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
[C] Temp. of deflection under load, 1.80 MPa	**102**	°C	ISO 75-1/-2
[C] Vicat softening temperature, B	**122**	°C	ISO 306
[C] Coeff. of linear therm. expansion, parallel	**70**	E-6/K	ISO 11359-1/-2
[C] Coeff. of linear therm. expansion, normal	**70**	E-6/K	ISO 11359-1/-2
[C] Burning Behav. at thickness h	**HB**	class	IEC 60695-11-10
Thickness tested	**0.7**	mm	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
[C] Volume resistivity	**>1E13**	Ohm*m	IEC 62631-3-1
[C] Surface resistivity	**>1E15**	Ohm	IEC 62631-3-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
[C] Water absorption	**0.6**	%	Sim. to ISO 62
[C] Humidity absorption	**0.2**	%	Sim. to ISO 62
[C] Density	**1190**	kg/m³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
[C] Injection Molding, melt temperature	**260**	°C	ISO 294
Injection Molding, mold temperature	**80**	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**100 - 120**	°C	-
Pre-drying - Time	**4 - 6**	h	-
Processing humidity	**≤0.03**	%	-
Melt temperature	**270 - 300**	°C	-
Mold temperature	**80 - 120**	°C	-
Zone 1	**260 - 280**	°C	-
Zone 2	**270 - 290**	°C	-
Zone 3	**270 - 300**	°C	-
Nozzle temperature	**270 - 290**	°C	-

Characteristics

Processing
Injection Molding

Special Characteristics
Platable

Delivery form
Pellets

Regional Availability
Europe, Asia Pacific

Additives
Release agent

Other text information

Injection molding
Injection Molding Recommendations