

LNPT[™] THERMOCOMP[™] COMPOUND DX06412H

DF-1006 EM MR BE

DESCRIPTION

LNP THERMOCOMP DX06412H compound is based on Polycarbonate (PC) resin containing 30% glass fiber. Added features of this grade include: Easy Molding, Mold Release and Healthcare.

GENERAL INFORMATION	
Features	Good Processability, Healthcare/Formula lock, Enhanced mold release, High stiffness/Strength, No PFAS intentionally added
Fillers	Glass Fiber
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding
INDUSTRY	SUB INDUSTRY
Hygiene and Healthcare	Pharmaceutical Packaging and Drug Delivery, Surgical devices, General Healthcare, Patient Testing
Packaging	Healthcare Packaging

TYPICAL PROPERTY VALUES

Revision 20240227

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, break	117	MPa	ASTM D638
Tensile Strain, break	2.4	%	ASTM D638
Tensile Modulus, 50 mm/min	9030	MPa	ASTM D638
Flexural Stress	172	MPa	ASTM D790
Flexural Modulus	8410	MPa	ASTM D790
IMPACT ⁽¹⁾			
Izod Impact, unnotched, 23°C	729	J/m	ASTM D4812
Izod Impact, notched, 23°C	90	J/m	ASTM D256
THERMAL ⁽¹⁾			
HDT, 1.82 MPa, 3.2mm, unannealed	135	°C	ASTM D648
PHYSICAL ⁽¹⁾			
Density	1.43	g/cm ³	ASTM D792
Mold Shrinkage, flow, 24 hrs ⁽²⁾	0.2	%	ASTM D955
INJECTION MOLDING ⁽³⁾			
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	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
- (3) 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.

ADDITIONAL PRODUCT NOTES

No PFAS intentionally added: The grade listed in this document does not contain PFAS intentionally added during Seller's manufacturing process and is not expected to contain unintentional PFAS impurities. Each user is responsible for evaluating the presence of unintentional PFAS impurities.

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