

# LNPTM THERMOCOMPTM COMPOUND DX05477

DFA-113 EM MR

## DESCRIPTION

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.

| GENERAL INFORMATION   |  |
|-----------------------|--|
| Features              | Flame Retardant, Good Processability, Enhanced mold release, High stiffness/Strength |
| Fillers               | Glass Fiber  |
| Polymer Types         | Polycarbonate (PC)   |
| Processing Techniques | Injection Molding  |

  

| INDUSTRY                   | SUB INDUSTRY                      |
|----------------------------|-----------------------------------|
| Building and Construction  | Building Component                |
| Consumer                   | Personal Accessory                |
| Electrical and Electronics | Mobile Phone - Computer - Tablets |
| Industrial                 | Electrical                        |

## TYPICAL PROPERTY VALUES

Revision 20231109

| PROPERTIES                                   | TYPICAL VALUES | UNITS             | TEST METHODS |
|--|----------------|-------------------|--------------|
| MECHANICAL <sup>(1)</sup>                    |                |                   |              |
| Tensile Stress, yield                        | 62             | MPa               | ASTM D638    |
| Tensile Stress, break                        | 57             | MPa               | ASTM D638    |
| Tensile Strain, yield                        | 4.2            | %                 | ASTM D638    |
| Tensile Strain, break                        | 7.4            | %                 | ASTM D638    |
| Tensile Modulus, 50 mm/min                   | 2820           | MPa               | ASTM D638    |
| Flexural Stress                              | 119            | MPa               | ASTM D790    |
| Flexural Modulus                             | 3440           | MPa               | ASTM D790    |
| Tensile Stress, yield                        | 70             | MPa               | ISO 527      |
| Tensile Stress, break                        | 69             | MPa               | ISO 527      |
| Tensile Strain, yield                        | 3.8            | %                 | ISO 527      |
| Tensile Strain, break                        | 4.4            | %                 | ISO 527      |
| Tensile Modulus, 1 mm/min                    | 3600           | MPa               | ISO 527      |
| Flexural Stress                              | 120            | MPa               | ISO 178      |
| Flexural Modulus                             | 3700           | MPa               | ISO 178      |
| IMPACT <sup>(1)</sup>                        |                |                   |              |
| Izod Impact, notched, 23°C                   | 96             | J/m               | ASTM D256    |
| Instrumented Dart Impact Energy @ peak, 23°C | 5              | J                 | ASTM D3763   |
| Izod Impact, notched 80*10*4 +23°C           | 7              | kJ/m <sup>2</sup> | ISO 180/1A   |
| THERMAL <sup>(1)</sup>                       |                |                   |              |
| HDT, 0.45 MPa, 3.2 mm, unannealed            | 145            | °C                | ASTM D648    |

| PROPERTIES                                   | TYPICAL VALUES | UNITS             | TEST METHODS |
|--|----------------|-------------------|--------------|
| HDT, 1.82 MPa, 3.2mm, unannealed             | 138            | °C                | ASTM D648    |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm        | 136            | °C                | ISO 75 /Af   |
| <b>PHYSICAL <sup>(1)</sup></b>               |                |                   |              |
| Density                                      | 1.271          | g/cm <sup>3</sup> | ASTM D792    |
| Mold Shrinkage, flow, 24 hrs <sup>(2)</sup>  | 0.5            | %                 | ASTM D955    |
| Mold Shrinkage, xflow, 24 hrs <sup>(2)</sup> | 0.6            | %                 | ASTM D955    |
| Mold Shrinkage, flow, 24 hrs <sup>(2)</sup>  | 0.5            | %                 | ISO 294      |
| Mold Shrinkage, xflow, 24 hrs <sup>(2)</sup> | 0.59           | %                 | ISO 294      |
| Density                                      | 1.26           | g/cm <sup>3</sup> | ISO 1183     |
| <b>INJECTION MOLDING <sup>(3)</sup></b>      |                |                   |              |
| 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                |              |
| 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.

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