LNP™ THERMOCOMP™ Compound DX06411

DF-1004 EM MR HC

DESCRIPTION

LNP THERMOCOMP DX06411 compound is based on Polycarbonate (PC) resin containing 20% glass fiber. Added features of this grade include: Easy Molding, Mold Release.

GENERAL INFORMATION	
Features	Good Processability, Enhanced mold release, High stiffness/Strength, No PFAS intentionally added
Fillers	Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
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 [1]			
Tensile Stress, break	82	MPa	ASTM D638
Tensile Strain, break	4.2	%	ASTM D638
Tensile Modulus, 50 mm/min	5740	MPa	ASTM D638
Flexural Stress	144	MPa	ASTM D790
Flexural Modulus	5650	MPa	ASTM D790
IMPACT [1]			
Izod Impact, unnotched, 23°C	747	J/m	ASTM D4812
Izod Impact, notched, 23°C	64	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	137	°C	ASTM D648
PHYSICAL [1]			
Density	1.4	g/cm³	ASTM D792
INJECTION MOLDING [2]			
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	

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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) 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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