

LNPT[™] COLORCOMP[™] COMPOUND DX06407H

D-1000 EM MR HC

DESCRIPTION

LNP COLORCOMP DX06407H compound is based on Polycarbonate (PC) resin. Added features of this grade include: Easy Molding, Good Mold Release, Healthcare

GENERAL INFORMATION	
Features	Good Processability, Aesthetics/Visual effects, Healthcare/Formula lock, Enhanced mold release, No PFAS intentionally added
Fillers	Unreinforced
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	Industrial Packaging

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, yld, Type I, 5 mm/min	63	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	58	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	6.2	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	94	%	ASTM D638
Tensile Modulus, 5 mm/min	2340	MPa	ASTM D638
Flexural Modulus, 1.3 mm/min, 50 mm span	2400	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	65	MPa	ISO 527
Tensile Stress, break, 5 mm/min	54	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	6.3	%	ISO 527
Tensile Strain, break, 5 mm/min	104	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress	91	MPa	ISO 178
Flexural Modulus, 2 mm/min	2290	MPa	ISO 178
IMPACT ⁽¹⁾			
Izod Impact, unnotched, 23°C	1310	J/m	ASTM D4812
Izod Impact, notched, 23°C	781	J/m	ASTM D256
Multiaxial Impact	69	J	ISO 6603
Instrumented Dart Impact Total Energy, 23°C	63	J	ASTM D3763
Izod Impact, unnotched 80*10*4 +23°C	224	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	9	kJ/m ²	ISO 180/1A
THERMAL ⁽¹⁾			

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT, 0.45 MPa, 3.2 mm, unannealed	103	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	94	°C	ASTM D648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	104	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	96	°C	ISO 75/Af
PHYSICAL ⁽¹⁾			
Specific Gravity	1.2	-	ASTM D792
Density	1.2	g/cm ³	ASTM D792
Mold Shrinkage, flow, 24 hrs ⁽²⁾	0.7 – 0.9	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs ⁽²⁾	1 – 3	%	ASTM D955
Melt Flow Rate, 300°C/1.2 kgf	10.5	g/10 min	ASTM D1238
Melt Volume Rate, MVR at 300°C/1.2 kg	12	cm ³ /10 min	ISO 1133
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	
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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