

LNPTM THERMOCOMPTM COMPOUND DX063131

DESCRIPTION

LNP THERMOCOMP DX06313I compound is based on Polycarbonate (PC) resin containing 30% glass fiber. Added features of this grade include: Impact Modified, Thin-Wall Molding, Improved Flow.

GENERAL INFORMATION		
Features	Thin Wall, High stiffness/Strength, Impact resistant, No PFAS intentionally added	
Fillers	Glass Fiber	
Polymer Types	Polycarbonate (PC)	
Processing Techniques	Injection Molding	

INDUSTRY	SUB INDUSTRY
Electrical and Electronics	Mobile Phone - Computer - Tablets

TYPICAL PROPERTY VALUES

Revision 20240715

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL (1)			
Tensile Stress, brk, Type I, 5 mm/min	105	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	2.7	%	ASTM D638
Tensile Modulus, 5 mm/min	7900	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	170	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	7500	MPa	ASTM D790
Tensile Stress, break, 5 mm/min	115	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.6	%	ISO 527
Tensile Modulus, 1 mm/min	8300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	175	MPa	ISO 178
Flexural Modulus, 2 mm/min	7200	MPa	ISO 178
IMPACT (1)			
Izod Impact, notched, 23°C	160	J/m	ASTM D256
Izod Impact, notched, -30°C	130	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	25	J	ASTM D3763
Izod Impact, unnotched 80*10*3 +23°C	54	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	50	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	18	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	14	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	17	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	15	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	65	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	55	kJ/m²	ISO 179/1eU
THERMAL (1)			
Vicat Softening Temp, Rate B/50	142	°C	ASTM D1525



NOTE TYPICAL VALUES UNITS TEST METHODS				
CFL, 40°C to 40°C, flow 2,260 1/°C ASTM E831 CFL, 40°C to 40°C, flow 6,860 1/°C ASTM E831 CFL, 40°C to 40°C, flow 6,860 1/°C 80 1359-2 CFL, 40°C to 40°C, flow 6,860 1/°C 80 1359-2 Vicat 50°C flow (20°C, flow) 142 °C 80 306 Vicat 50°C flowing Femp, Rate 8/190 142 °C 80 306 POTTAL 1.8 MP Fataw 80°10°4 spe4mm 136 °C 107 4/86 Relative Temp Index, Mech ylimpact ⁽²⁾ 80 °C U.7468 Relative Temp Index, Mech ylimpact ⁽²⁾ 80 °C U.7468 Relative Temp Index, Mech ylimpact ⁽²⁾ 80 °C W.7468 Relative Temp Index, Mech ylimpact ⁽²⁾ 80 °C W.7468 Relative Temp Index, Mech ylimpact ⁽²⁾ 80 °C W.7468 Pottage Cray (1) 142 °C M.7478 M.7479 Belative Temp Index, Mech ylimpact ⁽²⁾ 142 °C M.7470 M.748 Water Linday 142 °C M.748<	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE. 40°C to 40°C, slow 6.8E05 1,°C ASTM E83 CTE. 40°C to 40°C, slow 2.Fe05 1,°C R011389-2 CTE. 40°C to 40°C, slow 6.8E05 1,°C R011389-2 CTE. 40°C to 40°C, slow 6.8E05 1,°C R0306 Vicat Softening Temp, Rate 8/120 142 °C 80.306 HOT/R1. 1.8 MPa Flaxw 80°10°4 spe-84mm 136 °C 10.756/M Relative Temp Index, Bec. ¹⁰ 80 °C U.7468 Relative Temp Index, Mech w/o Impact ¹⁰ 80 °C U.7468 Relative Temp Index, Mech w/o Impact ¹⁰ 80 °C ASTM D792 Relative Temp Index, Mech w/o Impact ¹⁰ 142 °C ASTM D792 Relative Temp Index, Mech w/o Impact ¹⁰ 142 °C ASTM D792 Relative Temp Index, Mech w/o Impact ¹⁰ 142 °C ASTM D792 Molt Shrinkage, flow, 3.2 mm ¹⁰ 142 °C ASTM D1238 Molt Shrinkage, flow, 3.2 mm ¹⁰ 2 ycm ¹ So 62 Molt Shrinkage, flow, 3.2 mm ¹⁰ 2 ycm ¹	HDT, 1.82 MPa, 3.2mm, unannealed	136	°C	ASTM D648
CTE, 40°C to 40°C, flow 22E05 1/°C 85013592 CTE, 40°C to 40°C, flow 68E05 1/°C 80113592 Vicas Softening Temp, Rate 8/120 142 °C 150 306 HOT I/A I. 8 MPa Flatw 80 10°4 spe-64mm 136 °C 150 306 Relative Temp Index, Betc Pl 80 °C U. 7468 Relative Temp Index, Mech w/n impact Pl 80 °C U. 7468 Relative Temp Index, Mech w/n impact Pl 80 °C U. 7468 Relative Temp Index, Mech w/n impact Pl 80 °C W. 4568 Relative Temp Index, Mech w/n impact Pl 80 °C U. 7468 Relative Temp Index, Mech w/n impact Pl 80 °C W. 4568 Relative Temp Index, Mech w/n impact Pl 80 80 80 80 80 80 80 80 80 80 80 80 80 80 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 <	CTE, -40°C to 40°C, flow	2.2E-05	1/°C	ASTM E831
CTE, 40°C to 40°C, trilow 6.86°05 1/°C ISO 1359-2 Vicat Softening Temp, Rate 8/30 142 °C 180 306 Vicat Softening Temp, Rate 8/120 143 °C 180 306 Vicat Softening Temp, Rate 8/120 136 °C 180 75/14 Relative Temp Index, Meth w 80°10°4 spe-farm 80 °C U. 7468 Relative Temp Index, Mech w/ impact ⁽²⁾ 80 °C U. 7468 Relative Temp Index, Mech w/ jompact ⁽²⁾ 80 °C U. 7468 Relative Temp Index, Mech w/ jompact ⁽²⁾ 80 °C U. 7468 Relative Temp Index, Mech w/ jompact ⁽²⁾ 80 °C U. 7468 Relative Temp Index, Mech w/ jompact ⁽²⁾ 80 °C W. 7468 Relative Temp Index, Mech w/ jompact ⁽²⁾ 80 % M. 60 Proposition (20°C) South More of Mechanical	CTE, -40°C to 40°C, xflow	6.8E-05	1/°C	ASTM E831
Vicat Softening Temp, Rate 8/150 142 °C 180 306 Vicat Softening Temp, Rate 8/120 143 °C 180 306 HDT/IA/1.8 MPa Flatux 80°10² sp=64mm 80 °C 0.7488 Relative Temp Index, Rice. ^[2] 80 °C 0.17468 Relative Temp Index, Mech w/i mipact. ^[2] 80 °C 0.17468 Relative Temp Index, Mech w/i mipact. ^[2] 80 °C 0.17468 Relative Temp Index, Mech w/i mipact. ^[2] 80 °C 0.17468 Relative Temp Index, Mech w/i mipact. ^[2] 80 °C 0.17468 Relative Temp Index, Mech w/i mipact. ^[2] 80 %1 0.17468 Relative Temp Index, Mech w/i mipact. ^[2] 80 %51M07 0.17468 Relative Temp Index, Mech w/i mipact. ^[2] 1.42 80 5806 (method 0.18 \$60 (method 0.20 0.20 0.20 0.20 0.20 0.20 0.20 0.20 0.20 0.20 <td< th=""><th>CTE, -40°C to 40°C, flow</th><th>2.2E-05</th><th>1/°C</th><th>ISO 11359-2</th></td<>	CTE, -40°C to 40°C, flow	2.2E-05	1/°C	ISO 11359-2
Vicas Softening Temp, Rate B J120 143 °C ISO 306 HDT/AI, 1.8 MPa Flatw 80*10*4 sp=64mm 136 °C ISO 75/AI Relative Temp Index, Blec ⁽²⁾ 80 °C U.7 46B Relative Temp Index, Mech y/impact ⁽²⁾ 80 °C U.7 46B Relative Temp Index, Mech y/impact ⁽²⁾ 80 °C U.7 46B PHYSICAL ⁽¹⁾ Specific Gravity 1.42 °C ASTM D792 Moled Shrinkage, flow, 3.2 mm ⁽³⁾ 30 3-0.5 & SAB (Demotion) Melt Flow Rate, 300°C/5.0 kg 30 3-0.5 & SO (30 SO 1183 Density 1.42 g/cm³ ISO 1183 Water Absorption (23°C/ saturated) 0.4 % SO 62 Melt Volume Rate, MVR at 300°C/5.0 kg 2 m²/10 min ISO 133 LIX ELONG AND LIDING (30°C/5.0 kg E207780-100120256 ° * * LIX ELONG AND LIDING (30°C/5.0 kg E207780-100120256 ° * * LIX ELONG AND LIDING (30°C/5.0 kg E2077	CTE, -40°C to 40°C, xflow	6.8E-05	1/°C	ISO 11359-2
HOT/A/I. 1.8 MPa Flatw 80*10*4 sp=64mm 136 °C ISO 75/AI Relative Temp Index, Elec ⁽²⁾ 80 °C U1.746B Relative Temp Index, Mech w/ Impact ⁽²⁾ 80 °C U1.746B Relative Temp Index, Mech w/ Impact ⁽²⁾ 80 °C U1.746B Relative Temp Index, Mech w/ Impact ⁽²⁾ 80 °C U1.746B PWHSICALT V V ASTM D792 Bool of Shrinkage, flow, 3.2 mm ⁽³⁾ 1.42 . ASTM D792 Molt Shrinkage, flow, 3.2 mm ⁽³⁾ 30 . (3) (10 min ASTM D792 Molt Flow Rate, 300°(7.5 o. kgf) 1.42 . ASTM D1238 Water Absorption (23°C/ Saturated) 0.4 % 150 62-1 Molt Sture Absorption (23°C/ Saturated) 0.1 % 150 62-1 Mel Wollme Rate, MWa at 300°C/5.0 kg 2 m³/10 min 150 133 Ut Vellow Cate Lew Mark 1.0 mm 2 150 62-1 Ut Vellow Cate, 94HB Flame Class Rating 2.5 mm U1.94 Univelow Cate Saturated 2 2 -	Vicat Softening Temp, Rate B/50	142	°C	ISO 306
Relative Temp Index, Elec (P) 80 °C UL 746B Relative Temp Index, Mech w/Impact (P) 80 °C UL 746B Relative Temp Index, Mech w/Impact (P) 80 °C UL 746B PHYSICAL (I) FUNDIOLA (II) FUNDIOLA (II) Specific Gravity 142 SAMD P092 ASTM D1928 Mold Shrinkage, flow, 3.2 mm (P) 0.3 -0.5 % ASIM D1928 ASIM D1928 Melt Flow Rate, 300°C/5.0 kgf 1.42 g/min ASTM D1928 ASIM D1928 Water Absorption, (23°C/saturated) 0.4 % 50.62-1 183 Water Absorption (23°C/saturated) 0.1 % 50.62-1 183	Vicat Softening Temp, Rate B/120	143	°C	ISO 306
Relative Temp Index. Mech w/ Impact (a) 80 °C U. 7468 Relative Temp Index. Mech w/ Impact (a) 80 °C U. 7468 HYSICAL (1) Feetific Gravity 1.42 S ASIM D792 Mold Shrinkage, flow, 3.2 mm (a) 0.3 – 0.5 % ASIE method Melt Flow Rate, 300°C/5.0 kgf 30 9/ cm² ASTM D1238 Dessity 1.42 y/ cm² ISO 183 Molsture Absorption (23°C/saturated) 0.4 % 100 €2 Melt Volume Rate, MVR at 300°C/5.0 kg 2 cm²/ y/ min ISO 62 Melt Volume Rate, MVR at 300°C/5.0 kg 2 w³/ y/ min ISO 133 Melt Volume Rate, MVR at 300°C/5.0 kg 2 w³/ y/ min ISO 133 U. Vellow Card Link E207780-100120256 " - U. Vellow Card Link \$ * -	HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	136	°C	ISO 75/Af
Relative Temp Index, Mech w/o impact (?) 80 °C U1 7488 PHYSICAL (1) FUNDAL (2) ASTIN OPS2 Specific Gravity 1.42 - ASTIN OPS2 Mold Shrinkage, flow, 3.2 mm (3) 3.0 3.0 9/10 min ASTIN D1238 Melt Flow Rate, 300° (2/5.0 kgf) 1.42 9/10 min ASTIN D1238 Water Absorption (23° C/ saturated) 0.4 % 150 62-1 Molisture Absorption (23° C/ 50 kRH) 0.1 % 150 62-1 Melt Volume Rate, MVR at 300° (2,50 kg 2 2 m/y 10 min 150 62-1 UL Vellow Card Link E00788-100120256 1 9 133 3 FLUK ECHON CLUNC (4) 1 2 1 1 2 1 2 1 2 1 2 1 2 <th>Relative Temp Index, Elec ⁽²⁾</th> <th>80</th> <th>°C</th> <th>UL 746B</th>	Relative Temp Index, Elec ⁽²⁾	80	°C	UL 746B
PHYSICAL. ** ASTM D792 Specific Gravity 1.42 • ASTM D792 Mold Shrinkage, flow, 3.2 mm (³) 0.3 – 0.5 % ASRIC method Melt Flow Rate, 300°C/5.0 kgf 30 9/10 min ASTM D1238 Water Absorption (23°C/saturated) 0.4 % 50 62-1 Moisture Absorption (23°C/50 kgh) 0.1 % 50 62-1 Melt Volume Rate, MVR at 300°C/5.0 kg 2 2 m²/10 min 50 1133 5 50 62 1 UI. Vellow Card Link \$207780-100120256 ° 1 UI. Recognized, 94HB Flame Class Rating ≥1.5 mm U 9 DYing Temperature 20 ° 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 2 1 2 1 2 1 2 1 2 1 2 1 2 1 2 </th <th>Relative Temp Index, Mech w/impact (2)</th> <th>80</th> <th>°C</th> <th>UL 746B</th>	Relative Temp Index, Mech w/impact (2)	80	°C	UL 746B
Specific Gravity 1.42 - O. ASTM D792 Mold Shrinkage, flow, 3.2 mm ⁽³⁾ 0.3 – 0.5 % SABIC method Melt Flow Rate, 300°C/5.0 kgf 30 9/10 min ASTM D1238 Density 1.42 g/cm³ 150 183 Water Absorption, (23°C/ saturated) 0.4 % 150 62 Melt Volume Rate, MVR at 300°C/5.0 kg 22 cm³/10 min 150 62 Melt Volume Rate, MVR at 300°C/5.0 kg 22 m²/10 min 150 133 FLAME CHARACTERISTICS (2) 2 m²/10 min 150 133 U. Yellow Card Link £207780.100120256 - - - U. RECGION MOLDING (4) 2 mm U.94 - Drying Temperature 120 *C -	Relative Temp Index, Mech w/o impact (2)	80	°C	UL 746B
Mold Shrinkage, flow, 3.2 mm (³) 0.3 – 0.5 % Ball Cmethod Meit Flow Rate, 300°C/5.0 kgf 30 g/10 min ASTM D1238 Density 1.42 g/cm³ ISO 1183 Water Absorption, (23°C/5 surated) 0.4 % 50 62-1 Moisture Absorption (23°C/5 D8 kgl) 0.1 % 50 62-1 Meit Volume Rate, MVR at 300°C/5.0 kg 22 cm³/10 min bol 133 FLAME CHARACTERISTICS (²) U. Vellow Card Link £207780-100120256 ~ . U. Recognized, 94HB Flame Class Rating £207780-100120256 ~ . . U. Recognized, 94HB Flame Class Rating 120 mm U. 94 . DV ing Time Presture 120 C . <t< th=""><th>PHYSICAL (1)</th><th></th><th></th><th></th></t<>	PHYSICAL (1)			
Melt Flow Rate, 300°C/5.0 kgf 30 g/10 min ASTM D1238 Density 1.42 g/cm³ ISO 1183 Water Absorption (23°C/5 aturated) 0.4 % ISO 62-1 Moisture Absorption (23°C/5 okg RH) 0.1 % ISO 62-1 Melt Volume Rate, MVR at 300°C/5.0 kg 22 cm³/10 min ISO 1133 FLAME CHARACTERISTICS (*) UL Yellow Card Link E207780-100120256 mm U.94 UL Recognized, 94HB Flame Class Rating 20 mm U.94 NINECTION MOLDING (*) USPYING Time 3-4 Hrs Learn of the colspan="2">Learn of the colspan="2">Learn of the colspan="2">Mine (Cumulative) 48 Hrs Learn of the colspan="2">Learn of the colspan="2">Learn of the colspan="2">Mine (Cumulative) 30-3 % Learn of the colspan="2">Learn of the colspan="2">Learn of the colspan="2">Learn of the colspan="2">Mine (Cumulative) 30-330 % Learn of the colspan="2">Learn of the colspan="2">Lea	Specific Gravity	1.42	-	ASTM D792
Melt Flow Rate, 300°C/5.0 kgf 30 g/10 min ASTM D1238 Density 1.42 g/cm³ ISO 1183 Water Absorption (23°C/5 aturated) 0.4 % ISO 62-1 Moisture Absorption (23°C/5 okg RH) 0.1 % ISO 62-1 Melt Volume Rate, MVR at 300°C/5.0 kg 22 cm³/10 min ISO 1133 FLAME CHARACTERISTICS (*) UL Yellow Card Link E207780-100120256 mm U.94 UL Recognized, 94HB Flame Class Rating 20 mm U.94 NINECTION MOLDING (*) USPYING Time 3-4 Hrs Learn of the colspan="2">Learn of the colspan="2">Learn of the colspan="2">Mine (Cumulative) 48 Hrs Learn of the colspan="2">Learn of the colspan="2">Learn of the colspan="2">Mine (Cumulative) 30-3 % Learn of the colspan="2">Learn of the colspan="2">Learn of the colspan="2">Learn of the colspan="2">Mine (Cumulative) 30-330 % Learn of the colspan="2">Learn of the colspan="2">Lea	Mold Shrinkage, flow, 3.2 mm ⁽³⁾	0.3 – 0.5	%	SABIC method
Water Absorption (23°C / 50% RH) 0.4 % ISO 62-1 Moisture Absorption (23°C / 50% RH) 0.1 % ISO 62 Melt Volume Rate, MVR at 300°C / 5.0 kg 22 cm³/10 min ISO 1133 FLAME CHARACTERISTICS (2) UL Yellow Card Link E207780-100120256 - - UL Recognized, 94HB Flame Class Rating ≥1.5 mm UL 94 INJECTION MOLDING (4) Drying Temperature 120 °C - Drying Time (Cumulative) 48 Hrs - - Maximum Moisture Content 0.02 % -<		30	g/10 min	ASTM D1238
Moisture Absorption (23°C / 50% RH) 0.1 % ISO 62 Melt Volume Rate, MVR at 300°C/5.0 kg 22 cm³/10 min ISO 1133 FLAME CHARACTERISTICS (2) UL Yellow Card Link E207780-100120256 - - UL Recognized, 94HB Flame Class Rating ≥1.5 mm UL 94 INJECTION MOLDING (4) Tyring Time 120 °C Drying Time 3 - 4 Hrs Drying Time (Cumulative) 48 Hrs Melt Temperature 310 - 330 °C Nozzle Temperature 305 - 325 °C Front - Zone 3 Temperature 300 - 320 °C Middle - Zone 2 Temperature 300 - 320 °C Rear - Zone 1 Temperature 80 - 115 °C Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 pm Shot to Cylinder Size 40 - 60 %	Density	1.42	g/cm³	ISO 1183
Melt Volume Rate, MVR at 300°C/5.0 kg 22 cm³/10 min ISO 1133 FLAME CHARACTERISTICS ⁽²⁾ UL Yellow Card Link E207780-100120256 - - UL Recognized, 94HB Flame Class Rating ≥1.5 mm UL 94 INJECTION MOLDING ⁽⁴⁾ Drying Temperature 120 °C Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 % Melt Temperature 310 – 330 °C C Nozzle Temperature 305 – 325 °C C Front - Zone 3 Temperature 300 – 320 °C C Middle - Zone 2 Temperature 300 – 320 °C C Rear - Zone 1 Temperature 80 – 115 °C Mold Temperature 80 – 115 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 pm Shot to Cylinder Size 40 – 60 %	Water Absorption, (23°C/saturated)	0.4	%	ISO 62-1
FLAME CHARACTERISTICS (2) UL Yellow Card Link E207780-100120256	Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
UL Yellow Card Link E207780-100120256 -	Melt Volume Rate, MVR at 300°C/5.0 kg	22	cm³/10 min	ISO 1133
Du Recognized, 94HB Flame Class Rating ≥1.5 mm UL 94	FLAME CHARACTERISTICS (2)			
INJECTION MOLDING ⁽⁴⁾ Drying Temperature 120 °C Drying Time 3 - 4 Hrs Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 % Melt Temperature 310 - 330 °C Nozzle Temperature 305 - 325 °C Front - Zone 3 Temperature 300 - 320 °C Middle - Zone 2 Temperature 300 - 320 °C Rear - Zone 1 Temperature 290 - 310 °C Mold Temperature 80 - 115 °C Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 rpm Shot to Cylinder Size 40 - 60 %	UL Yellow Card Link	E207780-100120256	-	
INJECTION MOLDING ⁽⁴⁾ Drying Temperature 120 °C Drying Time 3 - 4 Hrs Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 % Melt Temperature 310 - 330 °C Nozzle Temperature 305 - 325 °C Front - Zone 3 Temperature 310 - 330 °C Middle - Zone 2 Temperature 300 - 320 °C Rear - Zone 1 Temperature 290 - 310 °C Mold Temperature 80 - 115 °C Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 rpm Shot to Cylinder Size 40 - 60 %	UL Recognized, 94HB Flame Class Rating	≥1.5	mm	UL 94
Drying Temperature 120 °C Drying Time 3 - 4 Hrs Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 % Melt Temperature 310 - 330 °C Nozzle Temperature 305 - 325 °C Front - Zone 3 Temperature 310 - 330 °C Middle - Zone 2 Temperature 300 - 320 °C Rear - Zone 1 Temperature 80 - 115 °C Mold Temperature 80 - 115 °C Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 rpm Shot to Cylinder Size 40 - 60 %	INJECTION MOLDING (4)			
Drying Time 3 - 4 Hrs Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 % Melt Temperature 310 - 330 °C Nozzle Temperature 305 - 325 °C Front - Zone 3 Temperature 310 - 330 °C Middle - Zone 2 Temperature 300 - 320 °C Rear - Zone 1 Temperature 80 - 115 °C Mold Temperature 80 - 115 °C Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 rpm Shot to Cylinder Size 40 - 60 %		120	°C	
Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 % Melt Temperature 310 – 330 °C Nozzle Temperature 305 – 325 °C Front - Zone 3 Temperature 310 – 330 °C Middle - Zone 2 Temperature 300 – 320 °C Rear - Zone 1 Temperature 80 – 310 °C Mold Temperature 80 – 115 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %		3 – 4	Hrs	
Maximum Moisture Content 0.02 % Melt Temperature 310 - 330 °C Nozzle Temperature 305 - 325 °C Front - Zone 3 Temperature 310 - 330 °C Middle - Zone 2 Temperature 300 - 320 °C Rear - Zone 1 Temperature 290 - 310 °C Mold Temperature 80 - 115 °C Back Pressure 0.3 - 0.7 MPa Screw Speed 40 - 70 rpm Shot to Cylinder Size 40 - 60 %		48	Hrs	
Melt Temperature 310-330 °C Nozzle Temperature 305-325 °C Front - Zone 3 Temperature 310-330 °C Middle - Zone 2 Temperature 300-320 °C Rear - Zone 1 Temperature 290-310 °C Mold Temperature 80-115 °C Back Pressure 0.3-0.7 MPa Screw Speed 40-70 rpm Shot to Cylinder Size 40-60 %		0.02		
Front - Zone 3 Temperature 310 – 330 °C Middle - Zone 2 Temperature 300 – 320 °C Rear - Zone 1 Temperature 290 – 310 °C Mold Temperature 80 – 115 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Melt Temperature	310 – 330	°C	
Middle - Zone 2 Temperature 300 – 320 °C Rear - Zone 1 Temperature 290 – 310 °C Mold Temperature 80 – 115 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Nozzle Temperature	305 – 325	°C	
Rear - Zone 1 Temperature 290 – 310 °C Mold Temperature 80 – 115 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Front - Zone 3 Temperature	310 – 330	°C	
Mold Temperature 80 – 115 °C Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Middle - Zone 2 Temperature	300 – 320	°C	
Back Pressure 0.3 – 0.7 MPa Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Rear - Zone 1 Temperature	290 – 310	°C	
Screw Speed 40 – 70 rpm Shot to Cylinder Size 40 – 60 %	Mold Temperature	80 – 115	°C	
Shot to Cylinder Size 40 – 60 %	Back Pressure	0.3 - 0.7	MPa	
	Screw Speed	40 – 70	rpm	
Vent Depth 0.025 – 0.076 mm	Shot to Cylinder Size	40 60	9/	
		40 - 60	/0	

⁽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⁾ UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

⁽³⁾ 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.

⁽⁴⁾ 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.



MORE INFORMATION

For curve data and CAE cards, please visit and register at https://materialfinder.sabic-specialties.com

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