LNP™ THERMOCOMP™ COMPOUND DX11354

DESCRIPTION

LNP THERMOCOMP DX11354 compound is based on Polycarbonate (PC) resin containing proprietary fillers and available in black color only. Added features of this grade include: Improved Plating Surface and Mechanical Performance targeted for Laser Direct Structuring (LDS) applications, Improved Impact.

GENERAL INFORMATION	
Features	Dielectrics, Laser Direct Structuring, Impact resistant, No PFAS intentionally added
Fillers	Unreinforced
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Automotive	Automotive Interiors
Consumer	Personal Accessory
Electrical and Electronics	Mobile Phone - Computer - Tablets
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20230607

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 50 mm/min	59	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	52	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	5.7	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	64	%	ASTM D638
Tensile Modulus, 50 mm/min	2560	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	91	MPa	ASTM D790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	90	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D790
IMPACT [1]			
Izod Impact, notched, 23°C	750	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	124	°C	ASTM D648
CTE, -40°C to 40°C, flow	6.3E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	6.9E-05	1/°C	ASTM E831
Relative Temp Index, Elec [2]	80	°C	UL 746B
Relative Temp Index, Mech w/impact [2]	80	°C	UL 746B
Relative Temp Index, Mech w/o impact [2]	80	°C	UL 746B
PHYSICAL [1]			
Density	1.27	g/cm³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.01	%	ASTM D570

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, flow, 24 hrs [3]	0.6 – 0.65	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs [3]	0.6 – 0.65	%	ASTM D955
Melt Flow Rate, 300°C/1.2 kgf	12	g/10 min	ASTM D1238
ELECTRICAL [1]			
Relative Permittivity, 1 GHz	2.92	-	IEC 60250
Dissipation Factor, 1 GHz	0.007	-	IEC 60250
FLAME CHARACTERISTICS [2]			
UL Yellow Card Link	E207780-101230645	-	-
UL Recognized, 94HB Flame Class Rating	≥0.6	mm	UL 94
INJECTION MOLDING [4]			
Drying Temperature	100 – 110	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	275 – 300	°C	
Nozzle Temperature	275 – 300	°C	
Front - Zone 3 Temperature	260 – 300	°C	
Middle - Zone 2 Temperature	255 – 295	°C	
Rear - Zone 1 Temperature	250 – 290	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	60 – 90	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	30 – 80	%	
Vent Depth	0.038 – 0.076	mm	

(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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