

LNP™ THERMOCOMP™ DX11355 compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

This is a PC based compound with good plating, surface, mechanical performance and flame retardant (Halogen free), a good candidate for Laser Direct Structuring applications.

General Information			
UL YellowCard	E207780-101214685		
Features	Flame Retardant		
	Good Surface Finish		
	Halogen Free		
	Platable		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.50	%	
Across Flow : 24 hr	0.50	%	
Water Absorption (24 hr, 50% RH)	0.010	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2600	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	58.0	MPa	
Break	52.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	5.4	%	
Break	70	%	
Flexural Modulus ⁴ (50.0 mm Span)	2400	MPa	ASTM D790
Flexural Strength ⁵			ASTM D790
Yield, 50.0 mm Span	90.0	MPa	
Break, 50.0 mm Span	89.0	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	800	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	114	°C	ASTM D648
CLTE			ASTM E831
Flow : -40 to 40°C	6.2E-5	cm/cm/°C	

Transverse : -40 to 40°C	6.7E-5	cm/cm/°C
Electrical	Nominal Value	Test Method
Relative Permittivity (1.00 GHz)	2.92	IEC 60250
Dissipation Factor (1.00 GHz)	7.0E-3	IEC 60250
Flammability	Nominal Value	Test Method
Flame Rating (0.600 mm)	V-0	UL 94
Injection	Nominal Value	Unit
Drying Temperature	100 to 110	°C
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	30 to 80	%
Hopper Temperature	60.0 to 80.0	°C
Rear Temperature	250 to 290	°C
Middle Temperature	255 to 295	°C
Front Temperature	260 to 300	°C
Nozzle Temperature	275 to 300	°C
Processing (Melt) Temp	275 to 300	°C
Mold Temperature	60.0 to 90.0	°C
Back Pressure	0.300 to 0.700	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.038 to 0.076	mm
NOTE		
1.	50 mm/min	
2.	Type I, 50 mm/min	
3.	Type I, 50 mm/min	
4.	1.3 mm/min	
5.	1.3 mm/min	

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