

LNP™ THERMOCOMP™ DX13006 compound

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LNP THERMOCOMP DX13006 is a compound based on Polycarbonate resin containing Glass Fiber. Added features of this material include: Easy Molding.

Also known as: LNP* THERMOCOMP* Compound DX13006

Product reorder name: DX13006

General Information			
Filler / Reinforcement	Glass Fiber		
Features	Good Moldability		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.31	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.10 to 0.30	%	Internal Method
Water Absorption (23°C, 24 hr)	0.12	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5300	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	90.0	MPa	
Break	85.0	MPa	
Tensile Strain			ISO 527-2/5
Yield	2.7	%	
Break	3.4	%	
Flexural Modulus ¹	4700	MPa	ISO 178
Flexural Stress	144	MPa	ISO 178
Flexural Strain at Break ²	4.9	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³ (23°C)	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	45	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, Unannealed, 64.0 mm Span	141	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	137	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	4.0E-5	cm/cm/°C	
Transverse : 23 to 60°C	7.3E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	

Suggested Max Moisture	0.020	%
Rear Temperature	293 to 304	°C
Middle Temperature	310 to 321	°C
Front Temperature	321 to 332	°C
Processing (Melt) Temp	304 to 327	°C
Mold Temperature	82.2 to 110	°C
Back Pressure	0.172 to 0.344	MPa
Screw Speed	30 to 60	rpm

NOTE		
1.	2.0 mm/min	
2.	2 mm/min	
3.	80*10*4	
4.	80*10*4	
5.	80*10*4 mm	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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