

LNP™ COLORCOMP™ DX13304C compound

Polycarbonate
SABIC Innovative Plastics

Message:

LNP* COLORCOMP* DX13304C is an unfilled Polycarbonate resin. Added features of this material include: very low level of leachable trace metals and anions, Easy Molding.
Also known as: LNP* COLORCOMP* Compound DX13304C
Product reorder name: DX13304C

General Information			
Features	Good formability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.20	g/cm ³	ASTM D792
--	1.19	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.44	%	ASTM D955
Transverse flow: 24 hours	0.57	%	ASTM D955
Water Absorption			
24 hr, 50% RH	0.11	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.18	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2430	MPa	ASTM D638
--	2360	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	63.0	MPa	ASTM D638
Yield	63.0	MPa	ISO 527-2/5
Fracture ³	52.0	MPa	ASTM D638
Fracture	52.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	6.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/5
Fracture ⁵	70	%	ASTM D638
Fracture	120	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁶	2400	MPa	ASTM D790
-- ⁷	2260	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	700	J/m	ASTM D256
23°C ⁸	19	kJ/m ²	ISO 180/1A
Unnotched Izod Impact (23°C)	No Break		ASTM D4812
Instrumented Dart Impact			
23°C, Total Energy	54.0	J	ASTM D3763
--	58.0	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	136	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁹	136	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	124	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹⁰	125	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	293 - 304	°C	
Middle Temperature	310 - 321	°C	
Front Temperature	321 - 332	°C	
Processing (Melt) Temp	304 - 327	°C	
Mold Temperature	82 - 110	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	Type 1, 5.0 mm/min		
5.	Type 1, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	80*10*4		
9.	80*10*4 mm		
10.	80*10*4 mm		

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