

LNP™ THERMOCOMP™ DF006LXN compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DF006LXN is a compound based on Polycarbonate resin containing 30% Glass Fiber. Added features of this material are: Low Extractable, NSF Listed.

Also known as: LNP* THERMOCOMP* Compound DF006LXN

Product reorder name: DF006LXN

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Low Extractables		
Agency Ratings	NSF Unspecified Rating		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792, ISO 1183
Water Absorption			
24 hr, 50% RH	0.070	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.070	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	8640	MPa	ASTM D638
Tensile Strength			
Break ²	114	MPa	ASTM D638
Break	114	MPa	ISO 527-2/5
Tensile Elongation			
Yield ³	2.7	%	ASTM D638
Break ⁴	3.2	%	ASTM D638
Break	7.5	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁵	8230	MPa	ASTM D790
-- ⁶	7870	MPa	ISO 178
Flexural Stress			
--	185	MPa	ISO 178
Break, 50.0 mm Span ⁷	149	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	140	J/m	ASTM D256
23°C ⁸	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	910	J/m	ASTM D4812
23°C ⁹	57	kJ/m ²	ISO 180/1U

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	144	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	145	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	140	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	141	°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 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.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	1.3 mm/min		
6.	2.0 mm/min		
7.	1.3 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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