

LNP™ THERMOCOMP™ DX10313 compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

DX10313 is high modulus polycarbonate, 50% glass filled, with balanced flow and impact strength

General Information			
UL YellowCard	E207780-102010576		
Filler / Reinforcement	Glass Fiber,50% Filler by Weight		
Features	Good Flow		
	Good Impact Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.61	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (300°C/5.0 kg)	18.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.050 to 0.15	%	
Across Flow : 3.20 mm	0.10 to 0.25	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	14300	MPa	ASTM D638
--	14100	MPa	ISO 527-2/1
Tensile Strength			
Break ²	154	MPa	ASTM D638
Break	152	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.3	%	ASTM D638
Break	2.2	%	ISO 527-2/5
Flexural Modulus			
--	12200	MPa	ASTM D790
-- ⁴	11900	MPa	ISO 178
Flexural Strength			
--	222	MPa	ASTM D790
--	206	MPa	ISO 178
--	207	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	16	kJ/m ²	ISO 179/2C
Charpy Unnotched Impact Strength (23°C)	43	kJ/m ²	ISO 179/2U

Notched Izod Impact (23°C)	170	J/m	ASTM D256
Unnotched Izod Impact (23°C)	670	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 3.20 mm)	128	°C	ASTM D648
CLTE			ASTM E831
Flow : -40 to 40°C	1.6E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.0E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 110	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	250 to 280	°C	
Middle Temperature	280 to 320	°C	
Front Temperature	280 to 320	°C	
Nozzle Temperature	280 to 320	°C	
Processing (Melt) Temp	280 to 320	°C	
Mold Temperature	90.0 to 120	°C	
Back Pressure	1.00 to 5.00	MPa	
Screw Speed	30 to 100	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	2.0 mm/min		

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