

LNP™ THERMOCOMP™ DX09402 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP THERMOCOMP DX09402 is a compound based on Polycarbonate containing Proprietary Filler(s).

Also known as: LNP* THERMOCOMP* Compound DX09402

Product reorder name: DX09402

General Information			
UL YellowCard	E121562-101357512		
Filler / Reinforcement	Proprietary		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.23	g/cm ³	
--	1.22	g/cm ³	
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.20 to 0.50	%	
Across Flow : 24 hr	0.30 to 0.60	%	
Water Absorption			
24 hr, 50% RH	0.14	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.18	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2970	MPa	ASTM D638
--	2990	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	56.0	MPa	ASTM D638
Yield	55.0	MPa	ISO 527-2/5
Break ³	45.0	MPa	ASTM D638
Break	47.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	5.3	%	ASTM D638
Yield	5.1	%	ISO 527-2/5
Break ⁵	37	%	ASTM D638
Break	21	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	2810	MPa	ASTM D790
-- ⁷	2640	MPa	ISO 178
Flexural Stress	81.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	430	J/m	ASTM D256
23°C ⁸	30	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	2300	J/m	ASTM D4812
23°C ⁹	200	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	41.9	J	ASTM D3763
--	43.8	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	138	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	136	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	129	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	125	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	5.4E-5	cm/cm/°C	
Transverse : -30 to 30°C	7.8E-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.	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.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	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

