

LNP™ THERMOCOMP™ DX15354 compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LNP* Thermocomp* DX15354 compound is a Polycarbonate (PC) compound with improved heat resistance performance, good plating, surface aesthetics and RF performance that makes it a good candidate for internal and external parts for Laser Direct Structuring (LDS) applications.

General Information			
Features	Electroplateable		
	Excellent appearance		
Uses	Laser Direct Structuring		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.29	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (330°C/2.16 kg)	63.0	cm ³ /10min	ISO 1133
Water Absorption (Equilibrium, 23°C, 50% RH)	0.13	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2920	MPa	ASTM D638
--	2940	MPa	ISO 527-2/1
Tensile Strength			
Fracture ²	59.0	MPa	ASTM D638
Fracture	58.0	MPa	ISO 527-2/50
Tensile Elongation			
Fracture ³	11	%	ASTM D638
Fracture	11	%	ISO 527-2/50
Flexural Modulus			
--	2890	MPa	ASTM D790
--	2880	MPa	ISO 178
Flexural Strength			
--	111	MPa	ASTM D790
--	112	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	61	J/m	ASTM D256
23°C ⁴	7.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	2200	J/m	ASTM D4812

23°C ⁵	180	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	168	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	155	°C	ASTM D648
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	6.3E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	6.7E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value		Test Method
Dielectric Constant (1.10 GHz)	2.95		Internal method
Dissipation Factor (1.10 GHz)	6.0E-3		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	135	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	280 - 315	°C	
Middle Temperature	290 - 335	°C	
Front Temperature	300 - 345	°C	
Nozzle Temperature	295 - 340	°C	
Processing (Melt) Temp	300 - 345	°C	
Mold Temperature	95 - 130	°C	
Back Pressure	0.300 - 0.700	MPa	
Screw Speed	40 - 90	rpm	
Vent Depth	0.025 - 0.080	mm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	80*10*3		
5.	80*10*3		

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