

LNP™ COLORCOMP™ DX98735H compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP COLORCOMP DX98735H is an unfilled Polycarbonate resin. Added feature of this grade is: Healthcare.

Also known as: LNP* COLORCOMP* Compound PDX-D-98735 HC

Product reorder name: DX98735H

General Information			
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.60 to 0.80	%	
Across Flow : 24 hr	0.80 to 1.0	%	
Water Absorption			
24 hr, 50% RH	0.14	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.21	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2340	MPa	ASTM D638
--	2250	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	63.0	MPa	ASTM D638
Yield	62.0	MPa	ISO 527-2/5
Break ³	54.0	MPa	ASTM D638
Break	58.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	6.3	%	ASTM D638
Yield	6.2	%	ISO 527-2/5
Break ⁵	66	%	ASTM D638
Break	170	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	2460	MPa	ASTM D790
-- ⁷	2280	MPa	ISO 178
Flexural Stress	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C ⁸	9.5	kJ/m ²	ISO 180/1A

Unnotched Izod Impact			
23°C	2500	J/m	ASTM D4812
23°C ⁹	210	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	61.0	J	ASTM D3763
--	77.1	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	139	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	138	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	132	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	126	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	6.8E-5	cm/cm/°C	
Transverse : -30 to 30°C	6.9E-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	304 to 316	°C	
Front Temperature	310 to 321	°C	
Processing (Melt) Temp	299 to 316	°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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