

LNP™ THERMOCOMP™ DX11354X compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

LNP THERMOCOMP Compound DX11354X is a colorable PC based compound with stable plating and RF performance, colored LDS material solution, good surface and processing window, high impact strength. It is a general purpose product available in internal and external parts for Laser Direct Structuring applications.

General Information			
UL YellowCard	E207780-101474809		
Features	Good Processability		
	Good Surface Finish		
	High Impact Resistance		
	Platable		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	20.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow : 24 hr	0.50 to 0.70	%	
Flow : 24 hr	0.50 to 0.70	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	0.050	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2400	MPa	ASTM D638
--	2320	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	55.0	MPa	ASTM D638
Yield	54.0	MPa	ISO 527-2/50
Break ³	45.0	MPa	ASTM D638
Break	51.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	5.0	%	ASTM D638
Yield	5.0	%	ISO 527-2/50
Break ⁵	70	%	ASTM D638
Break	84	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span ⁶	2380	MPa	ASTM D790

-- ⁷	2450	MPa	ISO 178
Flexural Stress			
--	86.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	86.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	700	J/m	ASTM D256
23°C ⁹	60	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	121	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	117	°C	ISO 75-2/Af
Vicat Softening Temperature	136	°C	ISO 306/B50, ASTM D1525 ¹¹
CLTE			ASTM E831
Flow : -40 to 40°C	6.5E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.1E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Constant (1.00 GHz)	3.03		ASTM D150
Dissipation Factor (1.00 GHz)	6.6E-3		ASTM D150
Injection	Nominal Value	Unit	
Drying Temperature	110 to 120	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	40.0 to 60.0	°C	
Rear Temperature	245 to 265	°C	
Middle Temperature	260 to 280	°C	
Front Temperature	260 to 280	°C	
Nozzle Temperature	255 to 275	°C	
Processing (Melt) Temp	260 to 280	°C	
Mold Temperature	80.0 to 140	°C	
NOTE			
1.	50 mm/min		
2.	Type I, 50 mm/min		
3.	Type I, 50 mm/min		
4.	Type I, 50 mm/min		
5.	Type I, 50 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		

9.	80*10*3
10.	80*10*4 mm
11.	Rate A (50°C/h), Loading 2 (50 N)

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