

LNP™ STAT-KON™ Lexan_LCF1506

compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP STAT-KON LEXAN_LCF1506 is a 15% carbon fiber, 6% PTFE reinforced polycarbonate.

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 15% filler by weight		
Additive	PTFE lubricant (6%)		
Features	Lubrication		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Molding Shrinkage			Internal method
Flow: 3.20mm	0.050 - 0.15	%	Internal method
Transverse flow: 3.20mm	0.20 - 0.30	%	Internal method
K (wear) Factor ¹	1000		Internal method
Static Decay ²	10	msec	FTMS 101B
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ³			ASTM D638
Yield	111	MPa	ASTM D638
Fracture	111	MPa	ASTM D638
Tensile Elongation ⁴ (Break)	4.1	%	ASTM D638
Flexural Modulus			ASTM D790
50.0mm span ⁵	9080	MPa	ASTM D790
100mm span ⁶	8420	MPa	ASTM D790
Flexural Strength			ASTM D790
Fracture, 50.0mm span ⁷	161	MPa	ASTM D790
Fracture, 100mm span ⁸	154	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
With steel-dynamic	0.19		ASTM D1894
With steel-static	0.41		ASTM D1894
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	53	J/m	ASTM D256
Unnotched Izod Impact (23°C)	280	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Energy at Peak Load)	11.8	J	ASTM D3763

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	142	°C	ASTM D648
0.45 MPa, unannealed, 6.40mm	144	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	138	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	139	°C	ASTM D648
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI	80.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+4	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	277 - 293	°C	
Middle Temperature	282 - 304	°C	
Front Temperature	288 - 316	°C	
Nozzle Temperature	288 - 316	°C	
Processing (Melt) Temp	288 - 316	°C	
Mold Temperature	71.1 - 104	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.025 - 0.076	mm	
NOTE			
1.	xE-10, PV=2000 psi-fpm vs Steel		
2.	5000V to <50V		
3.	Type 1, 5.0 mm/min		
4.	Type 1, 5.0 mm/min		
5.	1.3 mm/min		
6.	2.6 mm/min		
7.	1.3 mm/min		
8.	2.6 mm/min		

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