

LNP™ THERMOCOMP™ DX06313I compound

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

DX06313I is 30% glass fiber reinforced, impact modified polycarbonate resin. High flow and good ductility.

General Information			
UL YellowCard	E207780-100120256		
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Impact Modifier		
Features	Ductile		
	High Flow		
	Impact Modified		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/5.0 kg)	30	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (300°C/5.0 kg)	22.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.30 to 0.50	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.40	%	
Equilibrium, 23°C, 50% RH	0.10	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	7900	MPa	ASTM D638
--	8300	MPa	ISO 527-2/1
Tensile Strength			
Break ²	105	MPa	ASTM D638
Break	115	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.7	%	ASTM D638
Break	2.6	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	7500	MPa	ASTM D790
-- ⁵	7200	MPa	ISO 178
Flexural Stress			
--	175	MPa	ISO 178
Yield, 50.0 mm Span ⁶	170	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁷			ISO 179/1eA
-30°C	15	kJ/m ²	
23°C	17	kJ/m ²	
Charpy Unnotched Impact Strength ⁸			ISO 179/1eU
-30°C	55	kJ/m ²	
23°C	65	kJ/m ²	
Notched Izod Impact			
-30°C	130	J/m	ASTM D256
23°C	160	J/m	ASTM D256
-30°C ⁹	14	kJ/m ²	ISO 180/1A
23°C ¹⁰	18	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ¹¹			ISO 180/1U
-30°C	50	kJ/m ²	
23°C	54	kJ/m ²	
Instrumented Dart Impact (23°C, Total Energy)	25.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	136	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	136	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	142	°C	ASTM D1525, ISO 306/B50 ¹³
--	143	°C	ISO 306/B120
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	2.2E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.8E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	288 to 310	°C	
Middle Temperature	299 to 321	°C	
Front Temperature	310 to 332	°C	
Nozzle Temperature	304 to 327	°C	
Processing (Melt) Temp	310 to 332	°C	
Mold Temperature	82.2 to 116	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.025 to 0.076	mm	

NOTE	
1.	5.0 mm/min
2.	Type I, 5.0 mm/min
3.	Type I, 5.0 mm/min
4.	1.3 mm/min
5.	2.0 mm/min
6.	1.3 mm/min
7.	80*10*3 sp=62mm
8.	80*10*3 sp=62mm
9.	80*10*3
10.	80*10*3
11.	80*10*3
12.	80*10*4 mm
13.	Rate B (120°C/h), Loading 2 (50 N)

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