

LNP™ THERMOCOMP™ COMPOUND DX09309

REGION ASIA

DESCRIPTION

LNP* THERMOCOMP* DX09309 is a mineral filled polycarbonate compound with high dielectric constant.

TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	27	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4.2	%	ASTM D 638
Flexural Stress	60	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	68	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	94	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.4E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	2.24	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.65	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm (5)	0.56	%	SABIC method
Melt Volume Rate, MVR at 280°C/2.16 kg	20	cm ³ /10 min	ISO 1133
ELECTRICAL			
Dielectric Constant, 1.1 GHz	8	-	SABIC method
Dissipation Factor, 1.1 GHz	0.01	-	SABIC method
MECHANICAL PROPERTIES			
Flexural modulus	2490	MPa	ISO 178/1A
INJECTION MOLDING			
Drying Temperature	90 – 110	°C	
Drying Time	3 – 5	hrs	
Melt Temperature	280 – 320	°C	
Nozzle Temperature	280 – 320	°C	
Front - Zone 3 Temperature	280 – 320	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Middle - Zone 2 Temperature	280 – 320	°C	
Rear - Zone 1 Temperature	250 – 280	°C	
Mold Temperature	90 – 120	°C	
Back Pressure	1 – 5	MPa	
Screw Speed	30 – 100	rpm	

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