

LNP\* Thermocomp\* Compound DF006LXN

Americas: COMMERCIAL

LNP\* Thermocomp\* DF006LXN is a compound based on Polycarbonate resin containing Glass Fiber.

Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, brk, Type I, 5 mm/min	114	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	8630	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	149	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	8230	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	114	MPa	ISO 527
Tensile Strain, break, 5 mm/min	7.5	%	ISO 527
Flexural Stress	185	MPa	ISO 178
Flexural Modulus, 2 mm/min	7860	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	914	J/m	ASTM D 4812
Izod Impact, notched, 23°C	144	J/m	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	56	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m <sup>2</sup>	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	144	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	140	°C	ASTM D 648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	145	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.45	-	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.07	%	ASTM D 570
Density	1.45	g/cm <sup>3</sup>	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.07	%	ISO 62

Source GMD, last updated:2010/07/09

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	305 - 325	°C
Front - Zone 3 Temperature	320 - 330	°C
Middle - Zone 2 Temperature	310 - 320	°C
Rear - Zone 1 Temperature	295 - 305	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.2 - 0.3	MPa

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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