

## LNP\* Stat-kon\* Compound DX98477

Americas: COMMERCIAL

LNP\* Stat-Kon\* DX98477 is a compound based on Polycarbonate containing proprietary fillers. Characteristics of this grade are Statically Conductive.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
	Value	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	59	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	49	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4.8	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	21.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	2790	MPa	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span	2890	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	58	MPa	ISO 527
Tensile Stress, break, 5 mm/min	46	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	4.7	%	ISO 527
Tensile Strain, break, 5 mm/min	21.4	%	ISO 527
Tensile Modulus, 1 mm/min	2700	MPa	ISO 527
Flexural Stress	89	MPa	ISO 178
Flexural Modulus, 2 mm/min	2720	MPa	ISO 178
<b>IMPACT</b>			
	Value	Unit	Standard
Izod Impact, unnotched, 23°C	2330	J/m	ASTM D 4812
Izod Impact, notched, 23°C	87	J/m	ASTM D 256
Multiaxial Impact	34	J	ISO 6603
Instrumented Impact Total Energy, 23°C	45	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	234	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL</b>			
	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	142	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	133	°C	ASTM D 648
CTE, -30°C to 30°C, flow	6.7E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	6.6E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	142	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	132	°C	ISO 75/Af
<b>PHYSICAL</b>			
	Value	Unit	Standard
Specific Gravity	1.25	-	ASTM D 792
Density	1.25	g/cm <sup>3</sup>	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.16	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.8 - 1	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.8 - 1	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.24	%	ISO 62
<b>ELECTRICAL</b>			
	Value	Unit	Standard
Surface Resistivity	2.E+00 - 6.E+00	Ohm	ASTM D 257

Source GMD, last updated:2010/07/19

### 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
Screw Speed	30 - 60	rpm

Source GMD, last updated:2010/07/19

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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