

## LNP\* Thermocomp\* Compound DX07408\_BK1A639

### Americas: COMMERCIAL

Also known as: LNP\* Thermocomp\* Compound DX07408\_BK1A639

Product reorder name: DX07408\_BK1A639

LNP\* Thermocomp\* DX07408\_BK1A639 is a compound based on Polycarbonate containing proprietary fillers. Characteristic of this grade is UL Rated.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	1220	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1220	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Modulus, 5 mm/min	105600	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1820	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1820	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	97500	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, yield, 5 mm/min	126	MPa	ISO 527
Tensile Stress, break, 5 mm/min	126	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.2	%	ISO 527
Tensile Strain, break, 5 mm/min	2.2	%	ISO 527
Tensile Modulus, 1 mm/min	10040	MPa	ISO 527
Flexural Stress	172	MPa	ISO 178
Flexural Modulus, 2 mm/min	9100	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	59	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	10	cm-kgf/cm	ASTM D 256
Multiaxial Impact	35	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	179	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80°10*4 +23°C	39	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80°10*4 +23°C	9	kJ/m <sup>2</sup>	ISO 180/1A



(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±176°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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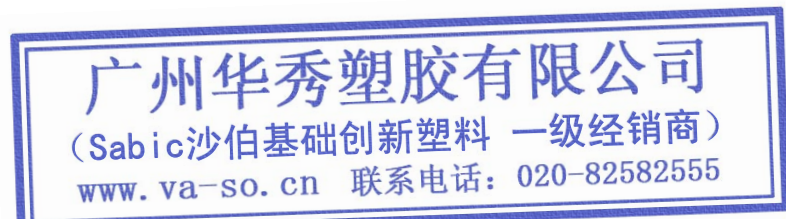
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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>THERMAL</b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	139	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	135	°C	ASTM D 648
CTE, -30°C to 30°C, flow	2.1E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	5.5E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	139	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	134	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.5	-	ASTM D 792
Density	1.5	g/cm <sup>3</sup>	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.09	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.1 - 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.6 - 0.9	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
<b>FLAME CHARACTERISTICS</b>			
UL Compliant, 94V-0 Flame Class Rating (3)(4)	1.5	mm	UL 94 by SABIC-IP



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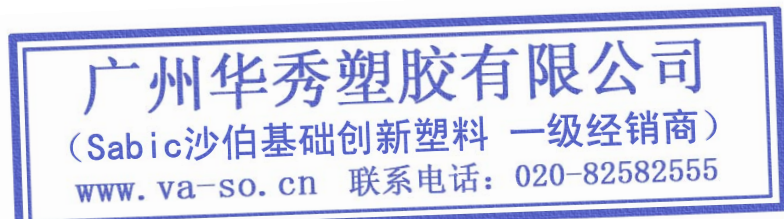
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	120	°C
Drying Time	4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	305 - 325	°C
Front - Zone 3 Temperature	320 - 330	°C
Middle - Zone 2 Temperature	310 - 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



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