

LNPTM THERMOCOMPTM COMPOUND DX09309

DESCRIPTION

LNPTM THERMOCOMPTM DX09309 is a mineral filled polycarbonate compound with high dielectric constant.

TYPICAL PROPERTY VALUES

Revision 20191216

| 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 |
| Flexural Modulus | 2490 | 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 | 0.65 | % | SABIC method |
| Mold Shrinkage, xflow, 3.2 mm | 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 |
| 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 | |
| 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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