



LNP™ STAT-KON™ Compound DX09315C

Asia Pacific: COMMERCIAL

LNP STAT-KON DX09315C is carbon fiber filled polycarbonate composite with good flow ability, and high level of cleanliness for the most demanding application. A unique feature of this material is its low C18-C40 hydrocarbons. This compound is manufactured using LNP CCS Technology.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1250	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Modulus, 5 mm/min	100000	kgf/cm ²	ASTM D 638
Flexural Stress	2040	kgf/cm ²	ASTM D 790
Flexural Modulus	82900	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	74	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	9	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	125	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.3E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.25	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.1 - 0.2	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.3 - 0.4	%	SABIC Method
Melt Volume Rate, MVR at 300°C/2.16 kg	26	cm ³ /10 min	ISO 1133
ELECTRICAL			
Surface Resistivity	1.E+04 - 5.E+05	Ohm	ASTM D 257



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
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