



LNP™ THERMOCOMP™ Compound DX05477

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound DFA-113 EM MR

Product reorder name: DX05477

LNP THERMOCOMP™ DX05477 is a compound based on Polycarbonate resin containing Glass Fiber. Added features of this material include: Easy Molding, Mold Release, Flame Retardant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	630	kgf/cm ²	ASTM D 638
Tensile Stress, break	580	kgf/cm ²	ASTM D 638
Tensile Strain, yield	4.2	%	ASTM D 638
Tensile Strain, break	7.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	28800	kgf/cm ²	ASTM D 638
Flexural Stress	1220	kgf/cm ²	ASTM D 790
Flexural Modulus	35100	kgf/cm ²	ASTM D 790
Tensile Stress, yield	70	MPa	ISO 527
Tensile Stress, break	69	MPa	ISO 527
Tensile Strain, yield	3.8	%	ISO 527
Tensile Strain, break	4.4	%	ISO 527
Tensile Modulus, 1 mm/min	3600	MPa	ISO 527
Flexural Stress	120	MPa	ISO 178
Flexural Modulus	3700	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	9	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	57	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	7	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	145	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	136	°C	ISO 75/Af
PHYSICAL			
Density	1.271	g/cm ³	ASTM D 792



LNP™ THERMOCOMP™ Compound DX05477

Americas: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Mold Shrinkage, flow, 24 hrs (5)	0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.6	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.5	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.59	%	ISO 294
Density	1.26	g/cm ³	ISO 1183



LNP™ THERMOCOMP™ Compound DX05477

Americas: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL 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