



LNP™ THERMOCOMP™ Compound DX06313I

Asia Pacific: COMMERCIAL

DX06313I is 30% glass fiber reinforced, impact modified polycarbonate resin. High flow and good ductility.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1070	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.7	%	ASTM D 638
Tensile Modulus, 5 mm/min	80500	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1730	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	76400	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	115	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.6	%	ISO 527
Tensile Modulus, 1 mm/min	8300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	175	MPa	ISO 178
Flexural Modulus, 2 mm/min	7200	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	16	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	13	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	254	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	54	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	50	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	18	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	14	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	17	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	15	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	65	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	55	kJ/m ²	ISO 179/1eU



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THERMAL			
Vicat Softening Temp, Rate B/50	142	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	136	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.8E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	2.2E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	142	°C	ISO 306
Vicat Softening Temp, Rate B/120	143	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	136	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.42	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.3 - 0.5	%	SABIC Method
Melt Flow Rate, 300°C/5.0 kgf	30	g/10 min	ASTM D 1238
Density	1.42	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.4	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
Melt Volume Rate, MVR at 300°C/5.0 kg	22	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	310 - 330	°C
Nozzle Temperature	305 - 325	°C
Front - Zone 3 Temperature	310 - 330	°C
Middle - Zone 2 Temperature	300 - 320	°C
Rear - Zone 1 Temperature	290 - 310	°C
Mold Temperature	80 - 115	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm