



LNP™ THERMOCOMP™ Compound DX06412H

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound DF-1006 EM MR BE

Product reorder name: DX06412H

LNP THERMOCOMP DX06412H is a compound based on Polycarbonate resin containing 30% Glass Fiber. Added features of this material include: Easy Molding, Mold Release.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1200	kgf/cm ²	ASTM D 638
Tensile Strain, break	2.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	92100	kgf/cm ²	ASTM D 638
Flexural Stress	1750	kgf/cm ²	ASTM D 790
Flexural Modulus	85700	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	135	°C	ASTM D 648
PHYSICAL			
Density	1.43	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.2	%	ASTM D 955



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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