



LNP™ THERMOCOMP™ Compound DX07350

Asia Pacific: COMMERCIAL

LEXAN® DX07350 resin is a glass filled, Non-brominated & Non-chlorinated flame retardant polycarbonate. High stiffness and good flow.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	660	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	560	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	5	%	ASTM D 638
Tensile Modulus, 5 mm/min	47900	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1180	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	42800	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	68	MPa	ISO 527
Tensile Stress, break, 5 mm/min	54	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.8	%	ISO 527
Tensile Strain, break, 5 mm/min	4.8	%	ISO 527
Tensile Modulus, 1 mm/min	4800	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	120	MPa	ISO 178
Flexural Modulus, 2 mm/min	4600	MPa	ISO 178
Pencil Hardness test, 0.5 kgf	F	-	ASTM D 3363
Pencil Hardness test, 1kgf	HB	-	ASTM D 3363
IMPACT			
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	3	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	112	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	50	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	47	kJ/m ²	ISO 180/1U



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IMPACT			
Izod Impact, notched 80*10*3 +23°C	4	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	4	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	3	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	3	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	75	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	61	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	112	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	102	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.7E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.6E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	3.7E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.6E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	109	°C	ISO 306
Vicat Softening Temp, Rate B/120	112	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	104	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.29	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.35 - 0.45	%	SABIC Method
Density	1.29	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.09	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.05	%	ISO 62
Melt Volume Rate, MVR at 280°C/2.16 kg	21	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Compliant, 94V-0 Flame Class Rating (3)(4)	0.8	mm	UL 94 by SABIC-IP



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	3 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	270 - 300	°C
Nozzle Temperature	270 - 290	°C
Front - Zone 3 Temperature	270 - 300	°C
Middle - Zone 2 Temperature	260 - 290	°C
Rear - Zone 1 Temperature	250 - 280	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	60 - 100	°C