



LNP™ THERMOCOMP™ Compound DX09309

Asia Pacific: COMMERCIAL

LNP* THERMOCOMP* DX09309 is a mineral filled polycarbonate compound with high dielectric constant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	270	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4.2	%	ASTM D 638
Flexural Stress	610	kgf/cm ²	ASTM D 790
Flexural Modulus	25300	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	94	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.4E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	2.24	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.65	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.56	%	SABIC Method
Melt Volume Rate, MVR at 280°C/2.16 kg	20	cm ³ /10 min	ISO 1133
ELECTRICAL			
Dielectric Constant, 1.1 GHz	8	-	SABIC Method
Dissipation Factor, 1.1 GHz	0.01	-	SABIC Method



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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