+135-3858-6433 (GuangDong)
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LNP™ THERMOCOMP™ Compound DX10313
Asia Pacific: COMMERCIAL

DX10313 is high modulus polycarbonate, 50% glass filled, with balanced flow and impact strength

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1570	kgf/cm²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.3	%	ASTM D 638
Tensile Modulus, 5 mm/min	146000	kgf/cm²	ASTM D 638
Flexural Stress	2260	kgf/cm²	ASTM D 790
Flexural Modulus	124400	kgf/cm²	ASTM D 790
Tensile Stress, break, 5 mm/min	152	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.2	%	ISO 527
Tensile Modulus, 1 mm/min	14100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	207	MPa	ISO 178
Flexural Stress, break, 2 mm/min	206	MPa	ISO 178
Flexural Modulus, 2 mm/min	11900	MPa	ISO 178
IMPACT			
Charpy Impact, unnotched, 23°C	43	kJ/m²	ISO 179/2C
Izod Impact, unnotched, 23°C	68	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	16	cm-kgf/cm	ASTM D 256
Charpy Impact, notched, 23°C	16	kJ/m²	ISO 179/2C
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	128	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.6E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.61	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.05 - 0.15	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.1 - 0.25	%	SABIC Method

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TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Melt Volume Rate, MVR at 300°C/5.0 kg	18	cm^3/10 min	ISO 1133

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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