+135-3858-6433 (GuangDong)
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LNP™ STAT-KON™ Compound DX05474

Americas: COMMERCIAL

Also known as: LNP™ STAT-KON™ Compound DC-1002 EM FR MR
Product reorder name: DX05474

LNP STAT-KON DX05474 is a compound based on Polycarbonate resin containing 10% Carbon Fiber. Added features of this material include: Electrically Conductive, Easy Molding, Flame Retardant, Mold Release.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1070	kgf/cm²	ASTM D 638
Tensile Strain, break	5.9	%	ASTM D 638
Tensile Modulus, 50 mm/min	140600	kgf/cm²	ASTM D 638
Flexural Stress	1610	kgf/cm²	ASTM D 790
Flexural Modulus	77300	kgf/cm²	ASTM D 790
Tensile Stress, break	107	MPa	ISO 527
Tensile Strain, break	6.4	%	ISO 527
Tensile Modulus, 1 mm/min	7680	MPa	ISO 527
Flexural Stress	169	MPa	ISO 178
Flexural Modulus	7300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	38	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	28	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	295	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	290	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.03E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.14E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	1.03E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	4.1E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	150	°C	ISO 75/Bf

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.
(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
(4) Internal measurements according to UL standards.
(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

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TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	146	°C	ISO 75/Af
PHYSICAL			
Density	1.29	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.3 - 0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.4 - 0.6	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.36	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.51	%	ISO 294
Density	1.29	g/cm³	ISO 1183
ELECTRICAL			
Surface Resistivity	1.E+03 - 1.E+07	Ohm	ASTM D 257

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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

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