

LNP* Thermocomp* Compound NX07354

Asia Pacific: COMMERCIAL

This is a PC/ABS compound, a good candidate for Laser Direct Structuring applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	53	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	43	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	42.3	%	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	2340	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	82	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	80	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2310	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	53	MPa	ISO 527
Tensile Stress, break, 5 mm/min	42	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	4.6	%	ISO 527
Tensile Strain, break, 5 mm/min	40	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	83	MPa	ISO 178
Flexural Strain, break, 2 mm/min	7.4	%	ISO 178
Flexural Modulus, 2 mm/min	2240	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	606	J/m	ASTM D 256
Izod Impact, notched 80°*10°*4 +23°C	54	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	106	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.55E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.48E-05	1/°C	ASTM E 831

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. 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) Own measurement according to UL.

Source, GMD, Last Update: 02/05/2009

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	105	°C	ISO 75/Af
PHYSICAL			
Density	1.23	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570
Mold Shrinkage, flow	0.74	%	SABIC Method
Mold Shrinkage, xflow	0.63	%	SABIC Method
Density	1.23	g/cm ³	ISO 1183
ELECTRICAL			
Relative Permittivity, 1 GHz	2.74	-	ASTM D 150
Dissipation Factor, 1 GHz	0.003	-	ASTM D 150

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	85 - 100	°C
Drying Time	6 - 8	hrs
Melt Temperature	240 - 280	°C
Nozzle Temperature	240 - 280	°C
Front - Zone 3 Temperature	240 - 270	°C
Middle - Zone 2 Temperature	240 - 260	°C
Rear - Zone 1 Temperature	240 - 260	°C
Mold Temperature	60 - 100	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm

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