

# LNP™ COLORCOMP™ COMPOUND DX06407H

D-1000 EM MR HC  
REGION AMERICAS

## DESCRIPTION

LNP COLORCOMP DX06407H is an unfilled Polycarbonate. Added features of this material include: Easy Molding, Mold Release, Healthcare

## TYPICAL PROPERTY VALUES

Revision 20170816

| PROPERTIES                               | TYPICAL VALUES | UNITS             | TEST METHODS |
|------------------------------------------|----------------|-------------------|--------------|
| <b>MECHANICAL</b>                        |                |                   |              |
| Tensile Stress, yld, Type I, 5 mm/min    | 63             | MPa               | ASTM D 638   |
| Tensile Stress, brk, Type I, 5 mm/min    | 58             | MPa               | ASTM D 638   |
| Tensile Strain, yld, Type I, 5 mm/min    | 6.2            | %                 | ASTM D 638   |
| Tensile Strain, brk, Type I, 5 mm/min    | 94             | %                 | ASTM D 638   |
| Tensile Modulus, 5 mm/min                | 2340           | MPa               | ASTM D 638   |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 2400           | MPa               | ASTM D 790   |
| Tensile Stress, yield, 5 mm/min          | 65             | MPa               | ISO 527      |
| Tensile Stress, break, 5 mm/min          | 54             | MPa               | ISO 527      |
| Tensile Strain, yield, 5 mm/min          | 6.3            | %                 | ISO 527      |
| Tensile Strain, break, 5 mm/min          | 104            | %                 | ISO 527      |
| Tensile Modulus, 1 mm/min                | 2300           | MPa               | ISO 527      |
| Flexural Stress                          | 91             | MPa               | ISO 178      |
| Flexural Modulus, 2 mm/min               | 2290           | MPa               | ISO 178      |
| <b>IMPACT</b>                            |                |                   |              |
| Izod Impact, unnotched, 23°C             | 1310           | J/m               | ASTM D 4812  |
| Izod Impact, notched, 23°C               | 781            | J/m               | ASTM D 256   |
| Multiaxial Impact                        | 69             | J                 | ISO 6603     |
| Instrumented Impact Total Energy, 23°C   | 63             | J                 | ASTM D 3763  |
| Izod Impact, unnotched 80*10*4 +23°C     | 224            | kJ/m <sup>2</sup> | ISO 180/1U   |
| Izod Impact, notched 80*10*4 +23°C       | 9              | kJ/m <sup>2</sup> | ISO 180/1A   |
| <b>THERMAL</b>                           |                |                   |              |
| HDT, 0.45 MPa, 3.2 mm, unannealed        | 94             | °C                | ASTM D 648   |
| HDT, 1.82 MPa, 3.2mm, unannealed         | 103            | °C                | ASTM D 648   |

| PROPERTIES                             | TYPICAL VALUES | UNITS             | TEST METHODS |
|----------------------------------------|----------------|-------------------|--------------|
| HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm | 96             | °C                | ISO 75/Bf    |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm  | 104            | °C                | ISO 75/Af    |
| <b>PHYSICAL</b>                        |                |                   |              |
| Specific Gravity                       | 1.2            | -                 | ASTM D 792   |
| Density                                | 1.2            | g/cm <sup>3</sup> | ASTM D 792   |
| Mold Shrinkage, flow, 24 hrs (5)       | 0.7 – 0.9      | %                 | ASTM D 955   |
| Mold Shrinkage, xflow, 24 hrs (5)      | 1 – 3          | %                 | ASTM D 955   |
| <b>INJECTION MOLDING</b>               |                |                   |              |
| 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               |              |

## DISCLAIMER

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