

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



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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

