

TECHNICAL DATA SHEET

XANTAR™ LDS 3750

Mitsubishi EP
PC FR

Processing

Injection molding

Delivery Form

Pellets

Additives

Release agent

Special Characteristics

Flame retardant, Platable

Product Text

Product Information

Laser Direct Structuring (LDS) *, Low Viscosity, Flame Retardant (Halogen free), Black color only

ISO 1043 PC FR

XANTAR Polycarbonate & Blends, your global partner for innovative added value

**The compound is intended specifically for the use in the process of manufacturing conducting path designs according to the German application of the patent 101 32 092 of LPKF Laser & Electronics AG (Osteriede 7 30827 Garbsen Germany). Please address straight to LPKF Laser & Electronics AG (www.LPKF.de).*

Processing/Physical Characteristics	Value	Unit	Standard
Melt volume-flow rate, MVR	14	cm ³ /10min	ISO 1133
Temperature	300	°C	
Load	1.2	kg	
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Mechanical Properties	Value	Unit	Standard
Tensile modulus	2300	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Yield strain	6	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Poisson's ratio	0.35		ISO 527
Puncture energy, +23°C	40	J	ISO 6603-2

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Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	126	°C	ISO 75-1/-2
Vicat softening temperature, B	145	°C	ISO 306
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.75	mm	
Electrical Properties	Value	Unit	Standard
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Other Properties	Value	Unit	Standard
Water absorption	0.35	%	Sim. to ISO 62
Density	1260	kg/m ³	ISO 1183
Test Specimen Production	Value	Unit	Standard
Injection molding, melt temperature	280	°C	ISO 294
Injection molding, mold temperature	100	°C	ISO 294
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	100 - 120	°C	
Pre-drying - time	4 - 6	h	
Processing humidity	≤0.03	%	
Melt temperature	270 - 300	°C	
Mold temperature	80 - 120	°C	
Zone 1	260 - 280	°C	
Zone 2	270 - 290	°C	
Zone 3	270 - 300	°C	
Nozzle temperature	270 - 290	°C	

Processing Information

Injection molding

Injection Molding Recommendations