

## LNP\* Thermocomp\* Compound DX05477

Americas: COMMERCIAL

Also known as: DFA-113 EM MR  
Product Reorder Name: DX05477

LNP THERMOCOMP\* DX05477 is a compound based on Polycarbonate resin containing Glass Fiber, Flame Retardant. Added features of this material include: Easy Molding.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield	62	MPa	ASTM D 638
Tensile Stress, break	57	MPa	ASTM D 638
Tensile Strain, yield	4.2	%	ASTM D 638
Tensile Strain, break	7.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	2820	MPa	ASTM D 638
Flexural Stress	119	MPa	ASTM D 790
Flexural Modulus	3440	MPa	ASTM D 790
Tensile Stress, yield	70	MPa	ISO 527
Tensile Stress, break	69	MPa	ISO 527
Tensile Strain, yield	3.8	%	ISO 527
Tensile Strain, break	4.4	%	ISO 527
Tensile Modulus, 1 mm/min	3600	MPa	ISO 527
Flexural Stress	120	MPa	ISO 178
Flexural Modulus	3700	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	96	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	5	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	7	kJ/m <sup>2</sup>	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	145	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	136	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Density	1.271	g/cm <sup>3</sup>	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.6	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.5	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.59	%	ISO 294
Density	1.26	g/cm <sup>3</sup>	ISO 1183

Source GMD, last updated:09/28/2004

### Processing

Parameter	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

Source GMD, last updated:09/28/2004

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(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.

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