LNP™ COLORCOMP™ COMPOUND EX10304C

DESCRIPTION

LNP COLORCOMP EX10304C is an unfilled polyetherimide clean compound with extremely high level of cleanliness for the most demanding application. This compound is manufactured using LNP CCS Technology.

TYPICAL PROPERTY VALUES

Revision 20191216

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	106	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	95	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	3290	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	160	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3020	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	1335	J/m	ASTM D 4812
Izod Impact, notched, 23°C	34	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	200	°C	ASTM D 648
Relative Temp Index, Elec [1]	105	°C	UL 746B
Relative Temp Index, Mech w/impact [1]	105	°C	UL 746B
Relative Temp Index, Mech w/o impact [1]	105	°C	UL 746B
PHYSICAL			
Density	1.27	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.5 – 0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.5 – 0.7	%	ASTM D 955
FLAME CHARACTERISTICS [1]			
UL Yellow Card Link	E207780-101339191	-	-
UL Recognized, 94V-2 Flame Class Rating	≥0.8	mm	UL 94
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	350 – 400	°C	
Nozzle Temperature	345 – 400	°C	
Front - Zone 3 Temperature	345 – 400	°C	
Middle - Zone 2 Temperature	340 – 400	°C	
Rear - Zone 1 Temperature	330 – 400	°C	
Mold Temperature	135 – 165	°C	
Back Pressure	0.3 – 0.7	MPa	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

(1) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

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