LNP™ THERMOCOMP™ COMPOUND 9X02540

PDX-02540

DESCRIPTION

LNP THERMOCOMP PDX-02540 is a compound based on a PET+PC Blend containing Proprietary Filler(s). Added feature of this grade is: Flame Retardant.

TYPICAL PROPERTY VALUES

Revision 20200109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	108	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	108	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.1	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.1	%	ASTM D 638
Tensile Modulus, 50 mm/min	7650	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	149	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	153	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	7030	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	103	MPa	ISO 527
Tensile Stress, break, 5 mm/min	103	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.1	%	ISO 527
Tensile Strain, break, 5 mm/min	2.1	%	ISO 527
Tensile Modulus, 1 mm/min	7240	MPa	ISO 527
Flexural Stress	149	MPa	ISO 178
Flexural Modulus, 2 mm/min	6530	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	558	J/m	ASTM D 4812
Izod Impact, notched, 23°C	51	J/m	ASTM D 256
Multiaxial Impact	1	J	ISO 6603
Instrumented Impact Total Energy, 23°C	13	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	38	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	130	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	122	°C	ASTM D 648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	133	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	120	°C	ISO 75/Af
Relative Temp Index, Elec [1]	75	°C	UL 746B
Relative Temp Index, Mech w/impact [1]	75	°C	UL 746B
Relative Temp Index, Mech w/o impact [1]	75	°C	UL 746B
PHYSICAL			
Density	1.47	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, xflow, 24 hrs	0.3 – 0.5	%	ASTM D 955

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
FLAME CHARACTERISTICS [1]			
UL Yellow Card Link	E121562-101284697	-	-
UL Recognized, 94V-0 Flame Class Rating	1.5	mm	UL 94
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	

(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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