LNP™ THERMOCOMP™ COMPOUND 9X94104

DESCRIPTION

LNP THERMOCOMP 9X94104 is a compound based on Polyetherimide resin containing Glass Fiber.

TYPICAL PROPERTY VALUES

Revision 20191216

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	169	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.5	%	ISO 527
Tensile Modulus, 1 mm/min	14500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	207	MPa	ISO 178
Flexural Strain, break, 2 mm/min	2.2	%	ISO 178
Flexural Modulus, 2 mm/min	10300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	30	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	9	kJ/m²	ISO 180/1A
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	210	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	0.15	%	SABIC method
Density	1.6	g/cm³	ISO 1183
Water Absorption, 23°C/24hrs	0.3	%	ISO 62-1
INJECTION MOLDING			
Drying Temperature	120 – 150	°C	
Drying Time	4 – 6	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	360 – 365	°C	
Front - Zone 3 Temperature	365 – 375	°C	
Middle - Zone 2 Temperature	355 – 365	°C	
Rear - Zone 1 Temperature	345 – 355	°C	
Mold Temperature	120 – 150	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	60 – 100	rpm	

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