LNP™ THERMOCOMP™ COMPOUND EC004APQ

EC004APQ

DESCRIPTION

LNP* THERMOCOMP* EC004APQ is a compound based on Polyetherimide containing 20% Carbon Fiber. Added features of this grade includes: Electrically Conductive, FAR25.853 Compliant.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Shear Modulus	4399	MPa	ASTM D732
Shear Strength	121.35	MPa	ASTM D732
Tensile Stress, brk, Type I, 5 mm/min	245	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.3	%	ASTM D 638
Tensile Modulus, 5 mm/min	19140	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	344	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	15800	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	711	J/m	ASTM D 4812
Izod Impact, notched, 23°C	109	J/m	ASTM D 256
THERMAL			
CTE, -40°C to 40°C, flow	5.4E-6	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	5.5E-5	1/°C	ISO 11359-2
HDT, 1.82 MPa, 3.2mm, unannealed	170	°C	ASTM D 648
PHYSICAL			
Mold Shrinkage, xflow, 24 hrs	0.4 – 0.7	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.2 – 0.4	%	ASTM D 955
Specific Gravity	1.33	-	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.15	%	ASTM D 570
Poisson's Ratio	0.44	-	ASTM E 132
ELECTRICAL			
Surface Resistivity	1.E+05 – 1.E+06	Ohm	ASTM D 257
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	325 – 350	°C	
Front - Zone 3 Temperature	325 – 350	°C	
Middle - Zone 2 Temperature	325 – 350	°C	
Rear - Zone 1 Temperature	325 – 350	°C	
Mold Temperature	160 – 175	°C	
Screw Speed	50 – 100	rpm	

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