LNP™ THERMOCOMP™ COMPOUND EC006E

EC-1006 EM

DESCRIPTION

LNP THERMOCOMP* EC006E is a compound based on Polyetherimide resin containing 30% Carbon Fiber. Added features of this material include: Easy Molding, Electrically Conductive

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	230	MPa	ASTM D 638
Tensile Strain, break	1.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	23300	MPa	ASTM D 638
Flexural Stress	314	MPa	ASTM D 790
Flexural Modulus	19160	MPa	ASTM D 790
Tensile Stress, break	215	MPa	ISO 527
Tensile Strain, break	1.3	%	ISO 527
Tensile Modulus, 1 mm/min	18470	MPa	ISO 527
Flexural Stress	306	MPa	ISO 178
Flexural Modulus	20800	MPa	ISO 178
IMPACT			
Instrumented Impact Energy @ peak, 23°C	6	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	34	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	206	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	208	°C	ISO 75/Af
PHYSICAL			
Density	1.394	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.17	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.1	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.5	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.1	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.51	%	ISO 294
Wear Factor Washer	75	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.52	-	ASTM D 3702 Modified: Manual
Static COF	0.48	-	ASTM D 3702 Modified: Manual
Density	1.39	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.25	%	ISO 62
INJECTION MOLDING			
Drying Temperature	120 – 150	°C	
Drying Time	4 – 6	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	360 – 365	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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