LNP™ THERMOCOMP™ COMPOUND EC006PXQ

EC006PXQ

DESCRIPTION

LNP* THERMOCOMP* EC006PXQ is a compound based on Polyetherimide containing 30% Carbon Fiber. Added features include: Electrically Conductive, Easy Molding, FAR25.853 Compliant.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Flexural Stress, break, 2 mm/min	334	MPa	ISO 178
Tensile Stress, brk, Type I, 5 mm/min	272	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.3 – 1.4	%	ASTM D 638
Tensile Modulus, 5 mm/min	29520	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	341	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23800	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	248	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.2	%	ISO 527
Tensile Modulus, 1 mm/min	27560	MPa	ISO 527
Flexural Modulus, 2 mm/min	23060	MPa	ISO 178
Compressive Strength	244	MPa	SABIC method
Shear Modulus	4726	MPa	ASTM D732
Shear Strength	128	MPa	ASTM D732
IMPACT			
Izod Impact, unnotched, 23°C	581	J/m	ASTM D 4812
Izod Impact, notched, 23°C	81	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	12	J	ASTM D 3763
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	195	°C	ASTM D 648
CTE, -40°C to 150°C, flow	7.2E-06	1/°C	ASTM E 831
CTE, -40°C to 150°C, xflow	5.8E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.39	-	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.11	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.03 – 0.1	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.1 – 0.6	%	ASTM D 955
Melt Flow Rate, 380°C/6.7 kgf	22	g/10 min	ASTM D 1238
Poisson's Ratio	0.44	-	ASTM E 132
ELECTRICAL			
Surface Resistivity	1.E+03	Ohm	ASTM D 257
INJECTION MOLDING			
Drying Temperature	120 – 150	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.02	%	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Temperature	380 – 400	°C	
Front - Zone 3 Temperature	380 – 400	°C	
Middle - Zone 2 Temperature	380 – 400	°C	
Rear - Zone 1 Temperature	380 – 400	°C	
Mold Temperature	165 – 180	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	50 – 100	rpm	
Injection Speed	40 – 70	mm/s	

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