LNP™ THERMOCOMP™ COMPOUND EX00781H

PDX-E-00781 EES
REGION ASIA

DESCRIPTION

LNP THERMOCOMP EX00781H is a compoud based on Polyetherimide containng Proprietary Filler(s). Added feature of this material is: Healthcare.

TYPICAL PROPERTY VALUES

Revision 20181031

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	91	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	90	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	5.9	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	5.3	%	ASTM D 638
Tensile Modulus, 5 mm/min	3320	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	145	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3150	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	91	MPa	ISO 527
Tensile Stress, break, 5 mm/min	89	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5.4	%	ISO 527
Tensile Strain, break, 5 mm/min	6	%	ISO 527
Tensile Modulus, 1 mm/min	3250	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	148	MPa	ISO 178
Flexural Modulus, 2 mm/min	3310	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	37	J/m	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	4	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	189	°C	ASTM D 648
Vicat Softening Temp, Rate B/120	213	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	189	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.31	-	ASTM D 792
Melt Flow Rate, 337°C/6.6 kgf	12.3	g/10 min	ASTM D 1238
Density	1.31	g/cm³	ISO 1183
Melt Volume Rate, MVR at 340°C/5.0 kg	10	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	350 – 400	°C	
Nozzle Temperature	345 – 400	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Front - Zone 3 Temperature	345 – 400	°C	
Middle - Zone 2 Temperature	340 – 400	°C	
Rear - Zone 1 Temperature	330 – 400	°C	
Mold Temperature	135 – 165	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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