LNP™ THERMOCOMP™ COMPOUND EX06430H

EX06430H

DESCRIPTION

LNP* THERMOCOMP* EX06430H is a compound based on Polyetherimide resin containing Proprietary Filler(s). Added feature of this grade is: Healthcare.

TYPICAL PROPERTY VALUES

Revision 20191216

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	110	MPa	ASTM D 638
Tensile Stress, break	90	MPa	ASTM D 638
Tensile Strain, yield	6.7	%	ASTM D 638
Tensile Strain, break	13.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	3660	MPa	ASTM D 638
Flexural Modulus	3660	MPa	ASTM D 790
Tensile Stress, yield	106	MPa	ISO 527
Tensile Stress, break	90	MPa	ISO 527
Tensile Strain, yield	6	%	ISO 527
Tensile Strain, break	10.8	%	ISO 527
Tensile Modulus, 1 mm/min	3500	MPa	ISO 527
Flexural Stress	133	MPa	ISO 178
Flexural Modulus	3500	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1383	J/m	ASTM D 4812
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	10	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	73	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	195	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	194	°C	ISO 75/Af
PHYSICAL			
Density	1.34 – 1.4	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.8	%	ASTM D 955
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	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Temperature	120 – 150	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	60 – 100	rpm	

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