LNP™ THERMOCOMP™ COMPOUND LX08411

LX08411

DESCRIPTION

LNP THERMOCOMP LX08411 is a compound based on Polyetheretherketone resin containing Carbon Fiber. Added feature of this material is: Opaque.

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	270	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	270	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	1.8	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	23510	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	366	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	366	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25000	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	775	J/m	ASTM D 4812
Izod Impact, notched, 23°C	70	J/m	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	341	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	327	°C	ASTM D 648
PHYSICAL			
Density	1.45	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.03	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2 – 0.28	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.75 – 0.85	%	ASTM D 955
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Front - Zone 3 Temperature	380 – 400	°C	
Middle - Zone 2 Temperature	380 – 400	°C	
Rear - Zone 1 Temperature	370 – 380	°C	
Mold Temperature	175 – 190	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	60 – 100	rpm	

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