LNP™ THERMOCOMP™ COMPOUND OCF62E

OCF-1008 EM

DESCRIPTION

LNP THERMOCOMP OCF62E is a compound based on PPS-Branched resin containing 10% Carbon Fiber, 30% Glass Fiber. Added feature of this material includes: Easy Molding

TYPICAL PROPERTY VALUES

Revision 20191212

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	157	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	157	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	0.7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	0.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	30320	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	205	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	206	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	19070	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	133	MPa	ISO 527
Tensile Stress, break, 5 mm/min	133	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	0.5	%	ISO 527
Tensile Strain, break, 5 mm/min	0.5	%	ISO 527
Tensile Modulus, 1 mm/min	28600	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	46	MPa	ISO 178
Flexural Modulus, 2 mm/min	20560	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	260	J/m	ASTM D 4812
Izod Impact, notched, 23°C	63	J/m	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	13	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	280	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	267	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.02E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.6E-05	1/°C	ASTM E 831
CTE, 23°C to 60°C, flow	1.02E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	4.6E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	281	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	268	°C	ISO 75/Af
PHYSICAL			
Density	1.66	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.1 – 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.7 – 1	%	ASTM D 955
Density	1.66	g/cm³	ISO 1183

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
INJECTION MOLDING			
Drying Temperature	120 – 150	°C	
Drying Time	4	hrs	
Melt Temperature	315 – 320	°C	
Front - Zone 3 Temperature	330 – 345	°C	
Middle - Zone 2 Temperature	320 – 330	°C	
Rear - Zone 1 Temperature	305 – 315	°C	
Mold Temperature	140 – 165	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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