LNP™ THERMOCOMP™ COMPOUND PDXE98480

PDX-E-98480 PS

DESCRIPTION

LNP THERMOCOMP PDXE98480 is a compound based on Polyetherimide with Proprietary Fillers. Added feature of this grade: Reinforced.

TYPICAL PROPERTY VALUES

Revision 20191219

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	180	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.7	%	ASTM D 638
Tensile Modulus, 5 mm/min	15100	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	254	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	13400	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	162	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.5	%	ISO 527
Tensile Modulus, 1 mm/min	14220	MPa	ISO 527
Flexural Stress	243	MPa	ISO 178
Flexural Modulus, 2 mm/min	12790	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	500	J/m	ASTM D 4812
Izod Impact, notched, 23°C	92	J/m	ASTM D 256
Multiaxial Impact	4	J	ISO 6603
Instrumented Impact Total Energy, 23°C	12	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	33	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	213	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	208	°C	ASTM D 648
CTE, -30°C to 30°C, flow	2.9E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	9.2E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	213	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	208	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.6	-	ASTM D 792
Density	1.6	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.12	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2 – 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.4 – 0.6	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.17	%	ISO 62
INJECTION MOLDING			
Drying Temperature	120 – 150	°C	
Drying Time	4 – 6	hrs	

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

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