LNP™ LUBRICOMP™ COMPOUND EX03599H

PDX-E-03599 EES HC

DESCRIPTION

LNP LUBRICOMP EX03599H is a compound based on Polyetherimide resin containing Proprietary Fillers. Added features of this material include: Healthcare, Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	105	MPa	ASTM D 638
Tensile Stress, break	88	MPa	ASTM D 638
Tensile Strain, yield	7	%	ASTM D 638
Tensile Strain, break	27.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	3330	MPa	ASTM D 638
Flexural Stress	151	MPa	ASTM D 790
Flexural Modulus	3480	MPa	ASTM D 790
Tensile Stress, yield	106	MPa	ISO 527
Tensile Stress, break	98	MPa	ISO 527
Tensile Strain, yield	6.8	%	ISO 527
Tensile Strain, break	9.7	%	ISO 527
Tensile Modulus, 1 mm/min	3180	MPa	ISO 527
Flexural Stress	112	MPa	ISO 178
Flexural Modulus	3140	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1377	J/m	ASTM D 4812
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	6	J	ASTM D 3763
Multiaxial Impact	2	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	89	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	190	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.32E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.14E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	4.39E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	4.19E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	187	°C	ISO 75/Af
PHYSICAL			
Density	1.28	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.8	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.72	%	ISO 294

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, xflow, 24 hrs	0.78	%	ISO 294
Dynamic COF	0.43	-	ASTM D 3702 Modified: Manual
Static COF	0.45	-	ASTM D 3702 Modified: Manual
Density	1.28	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.25	%	ISO 62
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	
Mold Temperature	120 – 150	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	60 – 100	rpm	

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