LNP™ THERMOCOMP™ COMPOUND WF006XXB

DESCRIPTION

THERMOCOMP* WF006XXB is a compound based on PBT containing 30% Glass. Added features include: Medium Flow, for use in medical devices and pharmaceutical applications. Healthcare management of change, biocompatible (ISO 10993 or USP Class VI), food contact compliant.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	120	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	120	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Modulus, 5 mm/min	9300	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	189	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	7580	MPa	ASTM D 790
Hardness, Rockwell R	118	-	ASTM D 785
Tensile Stress, yield, 5 mm/min	125	MPa	ISO 527
Tensile Stress, break, 5 mm/min	125	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2	%	ISO 527
Tensile Strain, break, 5 mm/min	2	%	ISO 527
Tensile Modulus, 1 mm/min	9300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	195	MPa	ISO 178
Flexural Modulus, 2 mm/min	8500	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	801	J/m	ASTM D 4812
Izod Impact, notched, 23°C	85	J/m	ASTM D 256
Izod Impact, notched, -30°C	80	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	10	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	45	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	45	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	5	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	215	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	215	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	207	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.52E-05	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	2.52E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	2.52E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.2E-04	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	215	°C	ISO 306
Vicat Softening Temp, Rate B/120	220	°C	ISO 306

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	200	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.53	-	ASTM D 792
Specific Volume	0.66	cm³/g	ASTM D 792
Water Absorption, 24 hours	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.3 – 0.8	%	SABIC method
Mold Shrinkage, flow, 1.5-3.2 mm	0.3 – 0.5	%	SABIC method
Mold Shrinkage, flow, 3.2-4.6 mm	0.5 – 0.8	%	SABIC method
Mold Shrinkage, xflow, 1.5-3.2 mm	0.4 – 0.6	%	SABIC method
Mold Shrinkage, xflow, 3.2-4.6 mm	0.6 – 0.9	%	SABIC method
Melt Flow Rate, 250°C/2.16 kgf	17	g/10 min	ASTM D 1238
Density	1.53	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.26	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 250°C/2.16 kg	13	cm³/10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>3.2E+16	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 3.2 mm	18.7	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	24.8	kV/mm	ASTM D 149
Relative Permittivity, 100 Hz	3.8	-	ASTM D 150
Relative Permittivity, 1 MHz	3.7	-	ASTM D 150
Dissipation Factor, 100 Hz	0.002	-	ASTM D 150
Dissipation Factor, 1 MHz	0.02	-	ASTM D 150
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	12	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	250 – 265	°C	
Nozzle Temperature	245 – 260	°C	
Front - Zone 3 Temperature	250 – 265	°C	
Middle - Zone 2 Temperature	245 – 260	°C	
Rear - Zone 1 Temperature	240 – 255	°C	
Mold Temperature	65 – 90	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	50 – 80	rpm	
Shot to Cylinder Size	40 – 80	%	
Vent Depth	0.025 – 0.038	mm	

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