LNP™ STAT-KON™ COMPOUND EX03319C

DESCRIPTION

LNP STAT-KON EX03319C is a polyetherimide compound reinforced with carbon fiber for good stiffness, dimension stability and has extremely high level of cleanliness for the most demanding application. A unique feature of this material is its low non-volatile residue (NVR). This compound is manufactured using LNP CCS Technology.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	224	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	16960	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	233	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	11600	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	354	J/m	ASTM D 4812
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	22	kJ/m²	ISO 179/1eU
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	205	°C	ASTM D 648
PHYSICAL			
Density	1.351	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.05 – 0.15	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.3 – 0.45	%	ASTM D 955
ELECTRICAL			
Volume Resistivity	5000 – 5000000	Ohm-cm	ASTM D 257
Surface Resistivity	5.E+03 – 5.E+05	Ohm	ASTM D 257
Static Decay, 5000V to <50V	0.1	< seconds	FTMS101B
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	350 – 380	°C	
Nozzle Temperature	345 – 380	°C	
Front - Zone 3 Temperature	345 – 380	°C	
Middle - Zone 2 Temperature	340 – 380	°C	
Rear - Zone 1 Temperature	330 – 380	°C	
Mold Temperature	135 – 165	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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