LNP™ STAT-KON™ COMPOUND NORYL_HMC1010

REGION EUROPE

DESCRIPTION

LNP™ STAT-KON™ Noryl_HMC1010 compound is a 10% Carbon fiber reinforced. Static dissipative. Nonbrominated, nonchlor- nated flame retardant system. UL94 V-1 rated.

TYPICAL PROPERTY VALUES

Revision 20190731

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	79	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	71	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	103	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	6890	MPa	ASTM D 790
Hardness, Rockwell R	122	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	83	mg/1000cy	ASTM D 1044
IMPACT			
Izod Impact, unnotched, 23°C	240	J/m	ASTM D 4812
Izod Impact, notched, 23°C	69	J/m	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	111	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	105	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.15	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.05 – 0.15	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.15 – 0.3	%	SABIC method
ELECTRICAL			
Volume Resistivity	8.E+03	Ohm-cm	ASTM D 257
Surface Resistivity	1.3E+04	Ohm	ASTM D 257
Static Decay, 5000V to <50V	0.01	< seconds	FTMS101B
FLAME CHARACTERISTICS (1)			
UL Recognized, 94V-1 Flame Class Rating	2	mm	UL 94
UL Recognized, 94-5VA Flame Class Rating	2	mm	UL 94
INJECTION MOLDING			
Drying Temperature	90 – 95	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	255 – 280	°C	
Nozzle Temperature	255 – 280	°C	
Front - Zone 3 Temperature	245 – 280	°C	
Middle - Zone 2 Temperature	230 – 275	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Rear - Zone 1 Temperature	220 – 270	°C	
Mold Temperature	65 – 90	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 70	%	
Vent Depth	0.038 – 0.051	mm	

(1) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

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