LNP™ STAT-KON™ COMPOUND RX08408

RX08408

DESCRIPTION

LNP STAT-KON RX08404 is a compound based on Nylon 66 containing Carbon Powder. Added features of this material include: Electrically Conductive, High Impact.

TYPICAL PROPERTY VALUES

Revision 20191212

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	46	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	26	%	ASTM D 638
Tensile Modulus, 50 mm/min	1960	MPa	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span	1760	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	47	MPa	ISO 527
Tensile Strain, break, 5 mm/min	26	%	ISO 527
Tensile Modulus, 1 mm/min	1930	MPa	ISO 527
Flexural Stress	61	MPa	ISO 178
Flexural Modulus, 2 mm/min	1850	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1720	J/m	ASTM D 4812
Izod Impact, notched, 23°C	141	J/m	ASTM D 256
Multiaxial Impact	25	J	ISO 6603
Instrumented Impact Total Energy, 23°C	22	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	196	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	12	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	195	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	60	°C	ASTM D 648
CTE, -30°C to 30°C, flow	1.1E-04	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	1.14E-04	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	165	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	117	°C	ISO 75/Af
PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.6	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	3 – 5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	3 – 5	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.87	%	ISO 62
ELECTRICAL			
Volume Resistivity	1000 – 1000000	Ohm-cm	ASTM D 257
Surface Resistivity	1.E+03 – 1.E+06	Ohm	ASTM D 257
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	280 – 305	°C	
Front - Zone 3 Temperature	295 – 305	°C	
Middle - Zone 2 Temperature	280 – 295	°C	
Rear - Zone 1 Temperature	265 – 275	°C	
Mold Temperature	95 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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