LNP™ STAT-KON™ COMPOUND WEF42I

WCF-1006 HI

DESCRIPTION

LNP STAT-KON WEF42I is a compound based on PBT resin containing 10% Carbon Fiber, 20% Glass Fiber. Added features of this grade include: High Impact, Electrically Conductive.

TYPICAL PROPERTY VALUES

Revision 20191212

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	94	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	21840	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	125	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	9990	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	99	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.5	%	ISO 527
Tensile Modulus, 1 mm/min	15830	MPa	ISO 527
Flexural Stress	169	MPa	ISO 178
Flexural Modulus, 2 mm/min	10520	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	710	J/m	ASTM D 4812
Izod Impact, notched, 23°C	125	J/m	ASTM D 256
Multiaxial Impact	4	J	ISO 6603
Instrumented Impact Total Energy, 23°C	16	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	45	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	219	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	205	°C	ASTM D 648
CTE, -30°C to 30°C, flow	2.1E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	1.34E-04	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	203	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	220	°C	ISO 75/Af
PHYSICAL			
Density	1.44	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.3 – 0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
Density	1.44	g/cm³	ISO 1183
ELECTRICAL			
Volume Resistivity	1.E+04 – 1.E+06	Ohm-cm	ASTM D 257
Surface Resistivity	1.E+02 – 1.E+05	Ohm	ASTM D 257
INJECTION MOLDING			
Drying Temperature	120	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	4	hrs	
Maximum Moisture Content	0.05	%	
Melt Temperature	240 – 265	°C	
Front - Zone 3 Temperature	260 – 270	°C	
Middle - Zone 2 Temperature	245 – 255	°C	
Rear - Zone 1 Temperature	220 – 230	°C	
Mold Temperature	80 – 100	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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