

# LNPT<sup>™</sup> THERMOCOMP<sup>™</sup> COMPOUND EX06430H

EX06430H

## DESCRIPTION

LNP THERMOCOMP EX06430H compound is based on Polyetherimide (PEI) resin containing mineral. Added features of this grade include: Healthcare, X-Ray Detectable.

GENERAL INFORMATION	
Features	Healthcare/Formula lock, X-Ray and metal detection, High temperature resistance, No PFAS intentionally added
Fillers	Mineral
Polymer Types	Polyetherimide (PEI)
Processing Techniques	Injection Molding

  

INDUSTRY	SUB INDUSTRY
Hygiene and Healthcare	Pharmaceutical Packaging and Drug Delivery, Surgical devices, General Healthcare, Patient Testing
Packaging	Industrial Packaging

## TYPICAL PROPERTY VALUES

Revision 20241028

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL <sup>(1)</sup></b>			
Tensile Stress, yield	110	MPa	ASTM D638
Tensile Stress, break	90	MPa	ASTM D638
Tensile Strain, yield	6.7	%	ASTM D638
Tensile Strain, break	13.5	%	ASTM D638
Tensile Modulus, 50 mm/min	3660	MPa	ASTM D638
Flexural Modulus	3660	MPa	ASTM D790
Tensile Stress, yield	106	MPa	ISO 527
Tensile Stress, break	90	MPa	ISO 527
Tensile Strain, yield	6	%	ISO 527
Tensile Strain, break	10.8	%	ISO 527
Tensile Modulus, 1 mm/min	3500	MPa	ISO 527
Flexural Stress	133	MPa	ISO 178
Flexural Modulus	3500	MPa	ISO 178
<b>IMPACT <sup>(1)</sup></b>			
Izod Impact, unnotched, 23°C	1383	J/m	ASTM D4812
Izod Impact, notched, 23°C	48	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	10	J	ASTM D3763
Izod Impact, unnotched 80*10*4 +23°C	73	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL <sup>(1)</sup></b>			
HDT, 1.82 MPa, 3.2mm, unannealed	195	°C	ASTM D648

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	194	°C	ISO 75/Af
<b>PHYSICAL <sup>(1)</sup></b>			
Density	1.34 – 1.4	g/cm <sup>3</sup>	ASTM D792
Mold Shrinkage, flow, 24 hrs <sup>(2)</sup>	0.7	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs <sup>(2)</sup>	0.8	%	ASTM D955
<b>INJECTION MOLDING <sup>(3)</sup></b>			
Drying Temperature	150	°C	
Drying Time	4 – 6	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	360 – 400	°C	
Rear - Zone 1 Temperature	360 – 380	°C	
Middle - Zone 2 Temperature	370 – 390	°C	
Front - Zone 3 Temperature	380 – 400	°C	
Nozzle Temperature	390 – 400	°C	
Mold Temperature	140 – 180	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw speed (Circumferential speed)	0.2 – 0.3	m/s	
Vent Depth	0.025 – 0.076	mm	

- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
- (3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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