

LNPT[™] THERMOCOMP[™] COMPOUND 2X04505

PDX-FP-E-04505

DESCRIPTION

LNP THERMOCOMP 2X04505 compound is based on Ethylene Tetrafluoroethylene (ETFE) resin containing 20% carbon fiber. Added features of this grade include: Electrically Conductive.

| GENERAL INFORMATION | |
|-----------------------|---|
| Features | Electrically Conductive, Carbon fiber filled, High stiffness/Strength |
| Fillers | Carbon Fiber |
| Polymer Types | Ethylene Tetrafluoroethylene Copolymer (ETFE) |
| Processing Techniques | Injection Molding |

| INDUSTRY | SUB INDUSTRY |
|----------------------------|--|
| Electrical and Electronics | Energy Management, Electronic Components |
| Industrial | Material Handling |

TYPICAL PROPERTY VALUES

Revision 20231109

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|--|----------------|-------------------|--------------|
| MECHANICAL ⁽¹⁾ | | | |
| Tensile Stress, yield | 89 | MPa | ISO 527 |
| Tensile Stress, break | 88 | MPa | ISO 527 |
| Tensile Strain, yield | 4.6 | % | ISO 527 |
| Tensile Strain, break | 4.9 | % | ISO 527 |
| Tensile Modulus, 1 mm/min | 11580 | MPa | ISO 527 |
| Flexural Stress | 319 | MPa | ISO 178 |
| Flexural Modulus | 18800 | MPa | ISO 178 |
| Tensile Stress, yld, Type I, 5 mm/min | 87 | MPa | ASTM D638 |
| Tensile Stress, brk, Type I, 5 mm/min | 85 | MPa | ASTM D638 |
| Tensile Strain, yld, Type I, 5 mm/min | 4.5 | % | ASTM D638 |
| Tensile Strain, brk, Type I, 5 mm/min | 4.8 | % | ASTM D638 |
| Tensile Modulus, 50 mm/min | 15160 | MPa | ASTM D638 |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 10340 | MPa | ASTM D790 |
| IMPACT ⁽¹⁾ | | | |
| Izod Impact, notched 80*10*4 +23°C | 23 | kJ/m ² | ISO 180/1A |
| Izod Impact, unnotched 80*10*4 +23°C | 58 | kJ/m ² | ISO 180/1U |
| Multiaxial Impact | 8 | J | ISO 6603 |
| Izod Impact, notched, 23°C | 272 | J/m | ASTM D256 |
| Izod Impact, unnotched, 23°C | 1030 | J/m | ASTM D4812 |
| Instrumented Dart Impact Energy @ peak, 23°C | 18 | J | ASTM D3763 |
| THERMAL ⁽¹⁾ | | | |
| HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm | 251 | °C | ISO 75/Bf |

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|--|----------------|-------------------|--------------|
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm | 207 | °C | ISO 75/Af |
| CTE, -40°C to 40°C, flow | 1.20E-05 | 1/°C | ISO 11359-2 |
| CTE, -40°C to 40°C, xflow | 7.80E-05 | 1/°C | ISO 11359-2 |
| HDT, 0.45 MPa, 3.2 mm, unannealed | 255 | °C | ASTM D648 |
| HDT, 1.82 MPa, 3.2mm, unannealed | 222 | °C | ASTM D648 |
| CTE, -40°C to 40°C, flow | 1.26E-05 | 1/°C | ASTM E831 |
| CTE, -40°C to 40°C, xflow | 7.74E-05 | 1/°C | ASTM E831 |
| PHYSICAL ⁽¹⁾ | | | |
| Density | 1.74 | g/cm ³ | ISO 1183 |
| Mold Shrinkage, flow, 24 hrs ⁽²⁾ | 1.1 | % | ISO 294 |
| Mold Shrinkage, xflow, 24 hrs ⁽²⁾ | 1.9 | % | ISO 294 |
| Density | 1.75 | g/cm ³ | ASTM D792 |
| Mold Shrinkage, flow, 24 hrs ⁽²⁾ | 1 – 1.2 | % | ASTM D955 |
| Mold Shrinkage, xflow, 24 hrs ⁽²⁾ | 1.8 – 2 | % | ASTM D955 |
| INJECTION MOLDING ⁽³⁾ | | | |
| Drying Temperature | 120 – 150 | °C | |
| Drying Time | 4 | Hrs | |
| Melt Temperature | 315 | °C | |
| Front - Zone 3 Temperature | 330 – 345 | °C | |
| Middle - Zone 2 Temperature | 310 – 320 | °C | |
| Rear - Zone 1 Temperature | 280 – 295 | °C | |
| Mold Temperature | 95 – 120 | °C | |
| Back Pressure | 0.2 – 0.3 | MPa | |
| Screw Speed | 30 – 60 | rpm | |

(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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