

LNPTM THERMOCOMPTM COMPOUND OFM76XXP

DESCRIPTION

LNP THERMOCOMP OFM76XXP compound is a 65% glass fiber and mineral reinforced polyphenylene sulfide. Added feature of this material include: high heat and tracking resistance, good insulation properties and flame resistance, excellent dimensional stability with low coefficient of thermal expansion and moisture absorption.

GENERAL INFORMATION	
Features	Flame Retardant, Low Moisture Absorption, Dimensional stability, Thermally conductive/Electrically isolative, Tracking resistance, No PFAS intentionally added
Fillers	Glass Fiber, Mineral
Polymer Types	Polyphenylene Sulfide, Linear (PPS, Linear)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Electrical and Electronics	Energy Management, Electrical Components and Infrastructure
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20250319

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL (1)			
Tensile Stress, brk, Type I, 5 mm/min	103	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	1.1	%	ASTM D638
Tensile Modulus, 5 mm/min	16800	MPa	ASTM D638
Flexural Strength, 1.3 mm/min, 50 mm span	167	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	16300	MPa	ASTM D790
Tensile Stress, break, 5 mm/min	105	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.1	%	ISO 527
Tensile Modulus, 1 mm/min	17100	MPa	ISO 527
Flexural Strength, 2 mm/min	170	MPa	ISO 178
Flexural Modulus, 2 mm/min	16500	MPa	ISO 178
IMPACT (1)			
Izod Impact, notched, 23°C	84	J/m	ASTM D256
Izod Impact, unnotched, 23°C	220	J/m	ASTM D4812
Izod Impact, notched 80*10*4 +23°C	8.6	kJ/m²	ISO 180/1A
Izod Impact, unnotched 80*10*4 +23°C	18.5	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 0°C	8.0	kJ/m²	ISO 180/1A
Izod Impact, unnotched 80*10*4 0°C	15	kJ/m²	ISO 180/1U
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	8.4	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	19	kJ/m²	ISO 179/1eU
THERMAL (1)			
HDT, 0.45 MPa, 3.2 mm, unannealed	273	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	262	°C	ASTM D648
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HDT/A, 1.8 MPa Flatw 80*10*4 sp=64mm 562 76 m	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Page	HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	275	°C	ISO 75/Bf
CTE CTP ASTM E881 40°C to 90°C, flow 1,66 ASTM E881 40°C to 30°C, flow 1,56 1,°C ASTM E881 40°C to 30°C, flow 1,56 1,°C ISD 1359-2 40°C to 30°C, flow 1,°C ISD 1359-2 40°C to 90°C, flow 3,265 1,°C ISD 11359-2 40°C to 190°C, flow 3,265 1,°C ISD 11359-2 40°C to 190°C, flow 1,°C ISD 11359-2 40°C to 192°C, flow 1,°C ISD 11359-2 40°C to 125°C, flow 1,°C ISD 11359-2 40°C to 125°C, flow 1,°C ISD 11359-2 40°C to 125°C, flow 40°C MIM 1641-07 40°C to 125°C, flow 40°C MIM 1641-07 40°C to 125°C, flow 40°C MIM 1641-07 40°C to 125°C, flow <t< td=""><td>HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm</td><td>262</td><td>°C</td><td>·</td></t<>	HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	262	°C	·
40°C to 90°C, filow 1,665 1,1°C ASTM E831 40°C to 90°C, filow 3.855 1,1°C ASTM E831 40°C to 40°C, filow 1,655 1,1°C 90 11359 2 40°C to 40°C, filow 1,665 1,1°C 80 11359 2 40°C to 90°C, filow 1,665 1,1°C 80 11359 2 40°C to 125°C, filow 1,665 1,1°C 80 11359 2 40°C to 125°C, filow 4,665 1,1°C 80 11359 2 40°C to 125°C, filow 4,665 1,1°C 80 11359 2 40°C to 125°C, filow 4,665 1,1°C 80 11359 2 40°C to 125°C, filow 4,665 1,1°C 80 11359 2 40°C to 125°C, filow 4,605 4,0°C 80 11359 2 40°C to 125°C, filow 4,0°C 80 11359 2 40°C 4,0°C 4,0	·			,
40°C to 90°C, xllow 3.3E5 1,°C ASTM E831 40°C to 40°C, low 1.5E6 1,°C IS01359-2 40°C to 40°C, flow 1.6E6 1,°C IS011359-2 40°C to 90°C, flow 1.6E6 1,°C IS011359-2 40°C to 125°C, flow 1.6E6 1,°C IS011359-2 40°C to 125°C, flow 4.6E6 1,°C ASTM E1461-07 40°C to 125°C, flow 4.6E6 1,°C ASTM E1461-07 40°C to 125°C, flow 1.2 1,°C ASTM E1461-07 40°C to 125°C, flow 1.2 1,°C ASTM E1461-07 40°C to 125°C, flow 1.2 1,°C 1,°C 40°C to 125°C, flow 1.2 1,°C 1,°C	-40°C to 90°C, flow	1.6E-5	1/°C	ASTM E831
40°C to 40°C, slow 2,9E5 1,°C ISO 11359-2 40°C to 90°C, slow 1,6E5 1,°C ISO 11359-2 40°C to 125°C, slow 1,°C ISO 11359-2 40°C to 125°C, slow 1,°C ISO 11359-2 40°C to 125°C, slow 40°C to 125°C, slow 1,°C ISO 11359-2 Thermal Conductivity trough-plane, 10°10°3ma sample 0.8 Win-K ASTME1461-07 Thermal Conductivity in plane, 25°0-4mm disc 1.5 Win-K ASTME1461-07 Specific Heat 1.2 1.9°C ASTMC351 Relative Temp Index, Blee ⁽⁰⁾ 130 °C U.7468 Relative Temp Index, Mech w/Impact ⁽⁰⁾ 130 °C U.7468 Relative Temp Index, Mech w/Impact ⁽⁰⁾ 130 °C U.7468 Relative Temp Index, Mech w/Impact ⁽⁰⁾ 100 °C U.7468 William Machine Michael (1) 100 °C U.7468 Relative Temp Index, Mech w/Impact ⁽⁰⁾ 0.2 M.5 M.5 William Machine Michael (1) 0.2 M.5 M.5 Weller (2) <td>-40°C to 90°C, xflow</td> <td>3.3E-5</td> <td></td> <td>ASTM E831</td>	-40°C to 90°C, xflow	3.3E-5		ASTM E831
-0°C to 90°C, flow 1,665 1,°C 101359-2 -40°C to 190°C, flow 3,255 1,°C 101359-2 -40°C to 125°C, flow 1,665 1,°C 15011359-2 -40°C to 125°C, flow 40°C to 125°C, flow 1,°C 1501359-2 Thermal Conductivity irrough-plane, 10°10°3 ms nample 0.8 Wm.* ASTM E1461-07 Thermal Conductivity irrough-plane, 25°0.4mm disc 1.2 1/g°C ASTM E1461-07 Relative Temp Index, Elec C ¹ 30 °C 0.7468 Relative Temp Index, Mech w/impact C ¹ 130 °C 0.7468 Relative Temp Index, Mech w/o impact C ¹ 18 °C 0.7468 Relative Temp Index, Mech w/o impact C ¹ 18 °C MSTM D792 Wester Absorption, (23°C/24hrs) 0.02 % MSTM D792 Wider Absorption, (23°C/24hrs) 0.02 % MSTM D792 Molds Shrinkage, flow D ¹ 2 XSIM D792 MSTM D792 ELECTRICAL C ¹ 2 XSIM D792 MSTM D792 Volume Resistivity 2 C XSIM	-40°C to 40°C, flow	1.5E-5	1/°C	ISO 11359-2
40°Ct o 90°C, slow 3,2E5 1/°C 10°1359-2 40°Ct 0 125°C, flow 1,6E5 1/°C 10°1359-2 40°Ct 0 125°C, flow 40°Ct 0 125°C, flow 10°C 10°1359-2 40°Ct 0 125°C, flow 40°Ct 0 125°C, flow 10°C 10°1359-2 Themal Conductivity through-plane, 10°10°3 mm sample 0.8 W/m. ASTM 1461-07 Specific lead 1.5 W/m. ASTM 161-07 Relative Temp Index, floc (°) 130 °C U.7468 Relative Temp Index, Mech w/mapet (°) 130 °C U.7468 Relative Temp Index, Mech w/mapet (°) 130 °C U.7468 Relative Temp Index, Mech w/mapet (°) 130 °C W.7468 Relative Temp Index, Mech w/mapet (°) 10 °C W.7468 Relative Temp Index, Mech w/mapet (°) 10 °C W.7468 Water Absorption, (23°C/24hrs) 0.0 S. S. Mold Shrinkage, flow (°) 0.1 \$. S. Mold Shrinkage, flow (°) 1.5±15 C. C. V	-40°C to 40°C, xflow	2.9E-5	1/°C	ISO 11359-2
1.6E5	-40°C to 90°C, flow	1.6E-5	1/°C	ISO 11359-2
4.0°C to 125°C, xflow 4.0°E s 1,°°C IS 011359-2 Thermal Conductivity tin-plane, 10°10°3 mm sample 8.8 W/m K ASTM E1461-07 Specific Heat 1.2 W/m K ASTM E1461-07 Relative Temp Index, Elec ^[2] 130 °C U.7468 Relative Temp Index, Mech w/n impact ^[2] 130 °C U.7468 Relative Temp Index, Mech w/n impact ^[2] 130 °C U.7468 Relative Temp Index, Mech w/n impact ^[2] 130 °C U.7468 Relative Temp Index, Mech w/n impact ^[2] 130 °C U.7468 Relative Temp Index, Mech w/n impact ^[2] 130 °C U.7468 Physical Conditions (mark w/n) impact ^[2] 130 °C U.7468 Physical Conditions (mark w/n) impact ^[2] 1.8 3.0° 2.0° 2.0° Mode Answering (mark w/n) impact ^[2] 1.8 3.0° 3.0° 2.0° Mode Answering (mark w/n) impact ^[2] 1.8° 1.8° 2.0° 2.0° Mode Answering (mark w/n) 1.8° <td>-40°C to 90°C, xflow</td> <td>3.2E-5</td> <td>1/°C</td> <td>ISO 11359-2</td>	-40°C to 90°C, xflow	3.2E-5	1/°C	ISO 11359-2
Thermal Conductivity through-plane, 10*10*3mm sample 0.8 W/m⋅K ASTME 1461-07 Thermal Conductivity in-plane, 25*0.4mm disc 1.5 W/m⋅K ASTME 1461-07 Specific Heat 1.2 1/9°C ASTMC 25T Relative Temp Index, Bec. [¹⁰ 130 °C U.7 468 Relative Temp Index, Mech w/impact [¹⁰ 130 °C U.7 46B Relative Temp Index, Mech w/impact [¹⁰ 130 °C U.7 46B Relative Temp Index, Mech w/impact [¹⁰ 130 °C U.7 46B Relative Temp Index, Mech w/impact [¹⁰ 130 °C U.7 46B Relative Temp Index, Mech w/impact [¹⁰ 130 °C U.7 46B Relative Temp Index, Mech w/impact [¹⁰ 18 °C 1476 Water Absorption, (23*°C/24hrs) 0.02 8 ASM D592 Most Strinkage, flow [¹⁰] 0.2 150 ASM Cented Mold Shrinkage, stlow [¹⁰] 1.2 £15 Q. ASM D257 Volume Resistivity 1.2 £15 Q. Q. ASM D257 Comparative Texticular (100 £1)	-40°C to 125°C, flow	1.6E-5	1/°C	ISO 11359-2
Thermal Conductivity in plane, 25°0.4mm disc 1.5 W/m × ASTME 1461-07 Specific Heat 1.2 1/9 °C ASTMI C351 Relative Temp Index, Elec ⁽²⁾ 130 °C U.7 468 Relative Temp Index, Mech w/ impact ⁽²⁾ 130 °C U.7 468 Relative Temp Index, Mech w/ impact ⁽²⁾ 130 °C U.7 468 Prysts CAL ⁽²⁾ Temp Index, Mech w/ impact ⁽²⁾ 130 °C U.7 468 Relative Temp Index, Mech w/ impact ⁽²⁾ 18 °C ASTM D792 Specific Gravity 1.8 °C ASTM D792 Water Absorption, (23°C/24hrs) 0.0 0.2 % 150 62-4 Moisture Absorption, (23°C/24hrs) 0.0 2.5 ASIM Captal 9 80 62-4 9 Moisture Absorption, (23°C/24hrs) 2.5 2.5 2.6 4.6 80 Miller Mechanic 9 9	-40°C to 125°C, xflow	4.0E-5	1/°C	ISO 11359-2
Specific Heat 1.2 Jg °C ASTM C351 Relative Temp Index, Elec (2) 130 °C U. 746B Relative Temp Index, Mech w/ Impact (2) 130 °C U. 746B Relative Temp Index, Mech w/ Impact (2) 130 °C U. 746B Relative Temp Index, Mech w/ Impact (2) 130 °C U. 746B Water Absorption, (20°C/24hrs) 1.8 2 ASTM D792 Water Absorption, (23°C/25% RH/24hrs) 0.02 % ASTM D25 Mold Shrinkage, flow (3) 0.01 % ASIM Cemetod Mold Shrinkage, flow (3) 0.2 X. ASIM Cemetod Mold Shrinkage, flow (3) 1.8 ± 15 0.0 ASTM D257 Wolume Resistivity 1.8 ± 15 0.0 ASTM D257 Comparative Tracking Index (U1) (PLC) (2) 1.8 ± 15 0.0 0.0 ASTM D257 Wolume Resistivity 2. E. ± 15 0.0 0.0 ASTM D257 United CHARACTERISTICs (2) 1.2 ± 15 0.0 0.0 0.0 0.0 0.0 0.0 0.0 0.0	Thermal Conductivity through-plane, 10*10*3mm sample	0.8	W/m-K	ASTM E1461-07
Relative Temp Index, Elec (2) 130 °C U1 7468 Relative Temp Index, Mech w/Impact (2) 130 °C U1 7468 Relative Temp Index, Mech w/Impact (2) 130 °C U1 7468 Relative Temp Index, Mech w/Impact (2) 130 °C U1 7468 PHYSICAL (1) Specific Gravity 1.8 2 ASM D792 Water Absorption, (23°C/24hrs) 0.01 % 150 62-1 Mold Shrinkage, flow (3) 0.01 % 368 Cmethod Mold Shrinkage, flow (3) 0.25 % 381 Cmethod Mold Shrinkage, stlow (3) 0.2 ASM D257 Water Resistivity 1.8:15 0.0 ASM D257 Wolfane Resistivity 1.8:15 0.0 ASM D257 Wolfane Clus (U) [PLC) (2) 1.8:15 0.0 0.0 ASM D257 Wolfane Clus (Will) [PLC) (2) 1.8:45 0.0 0.0 0.0 0.0 0.0 Wolfane Clus (Will) [PLC) (2) 2.0 0.0 0.0	Thermal Conductivity in-plane, 25*0.4mm disc	1.5	W/m-K	ASTM E1461-07
Relative Temp Index, Mech w/ impact (2) 130 °C Ul. 7468 Relative Temp Index, Mech w/o impact (2) 130 °C Ul. 7468 PHYSICAL (1) Specific Gravity 188 - ASTM D792 Water Absorption, (23°C/24hrs) 0.02 % ASTM D792 Moisture Absorption, (23°C/50% RH/24hrs) 0.02 % ASEM D624 Moisture Absorption, (23°C/50% RH/24hrs) 0.25 % ASEM Cemethod Moisture Absorption, (23°C/50% RH/24hrs) 0.4 % ASEM Cemethod Moisture Absorption, (23°C/50% RH/24hrs) 0.25 % ASEM Cemethod Moisture Absorption, (23°C/50% RH/24hrs) 0.25 % ASEM Cemethod Moisture Absorption, (23°C/50% RH/24hrs) 0.25 % ASEM Cemethod Moisture Absorption, (23°C/50% RH/24hrs) 0.2 ASEM Cemethod ASEM Cemethod Moisture Absorption, (23°C/50% RH/24hrs) 0.2 ASEM Cemethod ASEM Cemethod Assistance of Moisture Absorption, (23°C/50% RH/24hrs) ASEM Cemethod ASEM Cemethod ASEM Cemethod <t< td=""><td>Specific Heat</td><td>1.2</td><td>J/g-°C</td><td>ASTM C351</td></t<>	Specific Heat	1.2	J/g-°C	ASTM C351
Relative Temp Index, Mech w/o impact (*) 130 °C Ul 7468 PHYSICAL (*) Specific Gravity 1.8 - ASTM D792 Water Absorption, (23°C/24hrs) 0.02 % 506 6-1 Moisture Absorption, (23°C/50% RH/24hrs) 0.01 % 506 6-2 Moid Shrinkage, flow (*) 0.25 % ASIM Ceethod Mold Shrinkage, xlow (*) 0.4 % ASIM D257 US PHYSICAL (*) * * ASIM D257 Volume Resistivity >1.E+15 Ω cm W colspan="2">U 1.746A Volume Resistivity >1.E+15 Ω cm W colspan="2">U 1.746A Volume Resistivity >1.E+15 Ω cm W colspan="2">U 1.746A Volume Resistivity 2.E Volume Resistivity ½ cm ½ cm	Relative Temp Index, Elec ⁽²⁾	130	°C	UL 746B
PHYSICAL (**) Specific Gravity 1.8. ASTM D792 Water Absorption, (23°C/24hrs) 3.002 Moisture Absorption, (23°C/50% RH/24hrs) 3.002 Moisture Absorption, (23°C/50% RH/24hrs) 3.002 Moid Shrinkage, flow (**) Moid Shrinkage, flow (*	Relative Temp Index, Mech w/impact (2)	130	°C	UL 746B
Specific Gravity 1.8 . C ASTM D792 Water Absorption, (23°C/24hrs) 0.02 \$ 150 62-1 Moisture Absorption, (23°C/250% RH/24hrs) 0.01 \$ 150 62-4 Mold Shrinkage, flow (3) 0.25 \$ SABIC method Mold Shrinkage, xflow (3) 0.4 \$ SABIC method Butter LECT LICL (1) ** ** SABIC method ELECT RICAL (1) \$ ASTM D257 ** Volume Resistivity >1.E+15 Ω.cm ASTM D257 Volume Resistivity 0 Q.cm Q.cm V.de Volume Resistivity 2 Q.cm Q.cm V.de Volume Resistivity 2 Q.cm Q.cm V.de Value Leave Task Stating 2 Q.cm	Relative Temp Index, Mech w/o impact (2)	130	°C	UL 746B
Water Absorption, (23°C/24hrs) 0.02 % ISO 62-1 Moisture Absorption, (23°C/50% RH/24hrs) 0.01 % ISO 62-4 Mold Shrinkage, fflow (3) 0.25 % SABIC method Mold Shrinkage, xflow (3) 0.4 % SABIC method BLECTRICAL (1) W STATE PARTY ASTM D257 Volume Resistivity >1.E+15 Ωcm ASTM D257 Comparative Tracking Index (UL) (PLC) (2) >1.E+15 Ωcm ASTM D257 Comparative Tracking Index (UL) (PLC) (2) 0 Qc U. 746A ELMECHARACTERISTICS (2) U. 20780-104693831 - - - UL Recognized, 94V-0 Flame Class Rating 20.4 mm U. 94 UNIDECTION MOLDING (4) C - - Drying Temperature 100 – 140 C - - Melt Temperature 300 – 340 C - - Nozzle Temperature 310 – 340 C - - Front - Zone 3 Temperature 300 – 320 C - <t< td=""><td>PHYSICAL (1)</td><td></td><td></td><td></td></t<>	PHYSICAL (1)			
Moisture Absorption, (23°C/50% RH/24hrs) 0.01 % 150 62-4 Mold Shrinkage, fflow ⁽³⁾ 0.25 % SABIC method Mold Shrinkage, xflow ⁽³⁾ 0.4 % SABIC method ELECTRICAL ⁽¹⁾ ** SABIC method Volume Resistivity 1.£+15 Ω cm ASTM D257 Comparative Tracking Index (UL) [PLC) ⁽²⁾ 0 PLC Ode U.746A FLAME CHARACTERISTICS ⁽²⁾ U.746A ** ** Uk Recognized, 94V-0 Flame Class Rating 50-7780-104693831 ** ** ** Upoling Temperature 120-140 ** ** ** Drying Temperature 4-6 Hrs ** ** Melt Temperature 300-340 ** ** ** Nozzle Temperature 310-340 ** ** ** Front - Zone 3 Temperature 300-330 ** ** ** ** Mold Temperature 200-320 ** ** ** ** Mold Temperature 200-320	Specific Gravity	1.8	-	ASTM D792
Mold Shrinkage, flow (3) 0.25 % SABIC method Mold Shrinkage, xflow (3) 0.4 % SABIC method ELECTRICAL (1) V V X SATM D257 Volume Resistivity >1.E+15 Ω.cm ASTM D257 Comparative Tracking Index (UL) {PLC} (2) 0 Q.cm ASTM D257 Comparative Tracking Index (UL) {PLC} (2) 0 Q.cm ASTM D257 Ux Pellow Card Link £027780-104693831 - - - Ux Recognized, 94V-0 Flame Class Rating ≥0.4 mm UL 94 - INDECTION MOLDING (4) C -	Water Absorption, (23°C/24hrs)	0.02	%	ISO 62-1
Mold Shrinkage, xflow ⁽³⁾ ELECTRICAL ⁽¹⁾ Surface Resistivity > 1.E+15 Ω Ω Ω ASTM D257 Volume Resistivity > 1.E+15 Ω Ω Ω ΛSTM D257 Comparative Tracking Index (UL) (PLC) ⁽²⁾ 0 1.E+15 Ω Ω Ω Ω Ω ΛSTM D257 Comparative Tracking Index (UL) (PLC) ⁽²⁾ 0 1.E+15 Ω Ω Ω Ω Ω Ω Ω Ω Ω Ω Ω Ω Ω Ω Ω Ω Ω Ω Ω	Moisture Absorption, (23°C/50% RH/24hrs)	0.01	%	ISO 62-4
Surface Resistivity	Mold Shrinkage, flow (3)	0.25	%	SABIC method
Surface Resistivity >1.E+15 Ω cm ASTM D257 Volume Resistivity >1.E+15 Ω.cm ASTM D257 Comparative Tracking Index (UL) {PLC} (²) 0 PLC Code U. 746A FLAME CHARACTERISTICS (²) UL Vellow Card Link E207780-104693831 - - - UL Recognized, 94V-0 Flame Class Rating ≥0.4 mm UL 94 INJECTION MOLDING (⁴) US - 140 °C Drying Temperature 120 - 140 °C Melt Temperature 300 - 340 °C Nozzle Temperature 310 - 340 °C Nozzle Temperature 310 - 340 °C Middle Zone 2 Temperature 300 - 330 °C Middle Zone 2 Temperature 290 - 320 °C Mold Temperature 20 - 160 °C Back Pressure 0.3 - 0.7 MPa	Mold Shrinkage, xflow ⁽³⁾	0.4	%	SABIC method
Volume Resistivity >1.E+15 Ω.cm ASTM D257 Comparative Tracking Index (UL) {PLC} (²²) 0 PLC Code UL 746A FIAME CHARACTERISTICS (²) UL Yellow Card Link E207780-104693831 - - - UL Recognized, 94V-0 Flame Class Rating ≥0.4 mm UL 94 INJECTION MOLDING (⁴) Drying Temperature 120 – 140 °C - Melt Temperature 4 – 6 Hrs - Melt Temperature 310 – 340 °C - Nozzle Temperature 310 – 340 °C - Front - Zone 3 Temperature 300 – 330 °C - Middle - Zone 2 Temperature 300 – 330 °C - Rear-Zone 1 Temperature 290 – 320 °C - Mold Temperature 20.3 – 0.7 MPa -	ELECTRICAL (1)			
Comparative Tracking Index (UL) (PLC) ⁽²⁾ FLAME CHARACTERISTICS ⁽²⁾ UL Yellow Card Link E207780-104693831 □	Surface Resistivity	>1.E+15	Ω	ASTM D257
FLAME CHARACTERISTICS (2) UL Yellow Card Link	Volume Resistivity	>1.E+15	Ω.cm	ASTM D257
UL Yellow Card Link UL Recognized, 94V-0 Flame Class Rating Dying Temperature Drying Time Melt Temperature 300 - 340 300 - 340 C Tont - Zone 3 Temperature Middle - Zone 2 Temperature Mold Temperature 300 - 330 300 - 330 300 - 330 C Rear - Zone 1 Temperature 300 - 320 Mold Temperature 300 - 300 Mold Temperature 300 - 300 Mold Temperature 300 - 300 C Rear - Zone 1 Temperature 300 - 300 Mold Temp	Comparative Tracking Index (UL) {PLC} (2)	0	PLC Code	UL 746A
UL Yellow Card Link UL Recognized, 94V-0 Flame Class Rating Dying Temperature Drying Time Melt Temperature 300 - 340 300 - 340 C Tont - Zone 3 Temperature Middle - Zone 2 Temperature Mold Temperature 300 - 330 300 - 330 300 - 330 C Rear - Zone 1 Temperature 300 - 320 Mold Temperature 300 - 300 Mold Temperature 300 - 300 Mold Temperature 300 - 300 C Rear - Zone 1 Temperature 300 - 300 Mold Temp	FLAME CHARACTERISTICS (2)			
INJECTION MOLDING ⁽⁴⁾ Drying Temperature 120 – 140 °C Drying Time 4 – 6 Hrs Melt Temperature 300 – 340 °C Nozzle Temperature 310 – 340 °C Front - Zone 3 Temperature 310 – 340 °C Middle - Zone 2 Temperature 300 – 330 °C Rear - Zone 1 Temperature 290 – 320 °C Mold Temperature 120 – 160 °C Back Pressure 0.3 – 0.7 MPa	UL Yellow Card Link	E207780-104693831	-	
Drying Temperature 120 – 140 °C Drying Time 4 – 6 Hrs Melt Temperature 300 – 340 °C Nozzle Temperature 310 – 340 °C Front - Zone 3 Temperature 310 – 340 °C Middle - Zone 2 Temperature 300 – 330 °C Rear - Zone 1 Temperature 290 – 320 °C Mold Temperature 120 – 160 °C Back Pressure 0.3 – 0.7 MPa	UL Recognized, 94V-0 Flame Class Rating	≥0.4	mm	UL 94
Drying Temperature 120 – 140 °C Drying Time 4 – 6 Hrs Melt Temperature 300 – 340 °C Nozzle Temperature 310 – 340 °C Front - Zone 3 Temperature 310 – 340 °C Middle - Zone 2 Temperature 300 – 330 °C Rear - Zone 1 Temperature 290 – 320 °C Mold Temperature 120 – 160 °C Back Pressure 0.3 – 0.7 MPa	INJECTION MOLDING (4)			
Drying Time 4 – 6 Hrs Melt Temperature 300 – 340 °C Nozzle Temperature 310 – 340 °C Front - Zone 3 Temperature 310 – 340 °C Middle - Zone 2 Temperature 300 – 330 °C Rear - Zone 1 Temperature 290 – 320 °C Mold Temperature 120 – 160 °C Back Pressure 0.3 – 0.7 MPa		120 – 140	°C	
Melt Temperature 300 – 340 °C Nozzle Temperature 310 – 340 °C Front - Zone 3 Temperature 310 – 340 °C Middle - Zone 2 Temperature 300 – 330 °C Rear - Zone 1 Temperature 290 – 320 °C Mold Temperature 120 – 160 °C Back Pressure 0.3 – 0.7 MPa				
Nozzle Temperature 310 – 340 °C Front - Zone 3 Temperature 310 – 340 °C Middle - Zone 2 Temperature 300 – 330 °C Rear - Zone 1 Temperature 290 – 320 °C Mold Temperature 120 – 160 °C Back Pressure 0.3 – 0.7 MPa				
Middle - Zone 2 Temperature 300 – 330 °C Rear - Zone 1 Temperature 290 – 320 °C Mold Temperature 120 – 160 °C Back Pressure 0.3 – 0.7 MPa	•	310 – 340	°C	
Rear - Zone 1 Temperature 290 – 320 °C Mold Temperature 120 – 160 °C Back Pressure 0.3 – 0.7 MPa	Front - Zone 3 Temperature	310 – 340	°C	
Mold Temperature 120 – 160 °C Back Pressure 0.3 – 0.7 MPa	Middle - Zone 2 Temperature	300 – 330	°C	
Back Pressure 0.3 – 0.7 MPa	Rear - Zone 1 Temperature	290 – 320	°C	
	Mold Temperature	120 – 160	°C	
Screw Speed 50 – 100 rpm	Back Pressure	0.3 – 0.7	MPa	
	Screw Speed	50 – 100	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) 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.
- (3) 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.
- (4) 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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