LNP™ THERMOCOMP™ Compound 9X02841

PDX-02841

DESCRIPTION

LNP THERMOCOMP 9X02841 compound is based on Polycarbonate / Polybutylene Terephthalate (PC/PBT) blend containing 15% glass fiber.

GENERAL INFORMATION	
Features	High stiffness/Strength, No PFAS intentionally added
Fillers	Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
Polymer Types	Polycarbonate + PBT (PC+PBT)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 5 mm/min	83	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	83	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	2.7	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	2.7	%	ASTM D638
Tensile Modulus, 50 mm/min	5120	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	127	MPa	ASTM D790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	123	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	4600	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	80	MPa	ISO 527
Tensile Stress, break, 5 mm/min	80	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.6	%	ISO 527
Tensile Strain, break, 5 mm/min	2.6	%	ISO 527
Tensile Modulus, 1 mm/min	4880	MPa	ISO 527
Flexural Stress	115	MPa	ISO 178
Flexural Modulus, 2 mm/min	4480	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched, 23°C	522	J/m	ASTM D4812
Izod Impact, notched, 23°C	78	J/m	ASTM D256
Multiaxial Impact	4	J	ISO 6603
Instrumented Dart Impact Total Energy, 23°C	16	J	ASTM D3763
Izod Impact, unnotched 80*10*4 +23°C	31	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
THERMAL [1]			

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT, 0.45 MPa, 3.2 mm, unannealed	141	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	115	°C	ASTM D648
CTE, -30°C to 30°C, flow	4.1E-05	1/°C	ASTM D696
CTE, -30°C to 30°C, xflow	6.3E-05	1/°C	ASTM D696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	140	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	115	°C	ISO 75/Af
PHYSICAL (1)			
Density	1.33	g/cm³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.09	%	ASTM D570
Mold Shrinkage, flow, 24 hrs (2)	0.4 – 0.6	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs (2)	0.6 – 0.8	%	ASTM D955
Density	1.33	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62
INJECTION MOLDING (3)			
Drying Temperature	120	°C	
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	

(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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