LNP™ THERMOCOMP™ Compound ECF62

ECF-1008

DESCRIPTION

LNP THERMOCOMP ECF62 compound is based on Polyetherimide (PEI) resin containing 30% glass fiber, 10% carbon fiber. Added features of this grade include: Electrically Conductive.

GENERAL INFORMATION	
Features	Electrically Conductive, Carbon fiber filled, High stiffness/Strength, High temperature resistance, No PFAS intentionally added
Fillers	Carbon Fiber, Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
Polymer Types	Polyetherimide (PEI)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component
Consumer	Personal Accessory
Electrical and Electronics	Mobile Phone - Computer - Tablets
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, break	185	MPa	ASTM D638
Tensile Strain, break	1.5	%	ASTM D638
Tensile Modulus, 50 mm/min	17920	MPa	ASTM D638
Flexural Stress	268	MPa	ASTM D790
Flexural Modulus	15850	MPa	ASTM D790
IMPACT [1]			
Izod Impact, unnotched, 23°C	485	J/m	ASTM D4812
Izod Impact, notched, 23°C	69	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	212	°C	ASTM D648
CTE, -40°C to 40°C, flow	2.52E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	2.34E-05	1/°C	ASTM E831
PHYSICAL [1]			
Density	1.57	g/cm³	ASTM D792
Mold Shrinkage, flow, 24 hrs [2]	0.1 – 0.2	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs [2]	0.3 – 0.4	%	ASTM D955
INJECTION MOLDING [3]			
Drying Temperature	150	°C	
Drying Time	4 – 6	Hrs	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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