LNP™ THERMOCOMP™ Compound EX06430H

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound EX06430H
Product reorder name: EX06430H

LNP THERMOCOMP EX06430H is a compound based on Polyetherimide resin containing Proprietary Filler(s). Added feature of this grade is: Healthcare.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	1120	kgf/cm²	ASTM D 638
Tensile Stress, break	920	kgf/cm²	ASTM D 638
Tensile Strain, yield	6.7	%	ASTM D 638
Tensile Strain, break	13.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	37300	kgf/cm²	ASTM D 638
Flexural Modulus	37400	kgf/cm²	ASTM D 790
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
IMPACT			
Izod Impact, unnotched, 23°C	141	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	111	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	73	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	195	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	194	°C	ISO 75/Af
PHYSICAL			
Density	1.34 - 1.4	g/cm³	ASTM D 792

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.
(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
(4) Internal measurements according to UL standards.
(5) 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.
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Mold Shrinkage, flow, 24 hrs (5)	0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.8	%	ASTM D 955

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120 - 150	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	360 - 365	°C
Front - Zone 3 Temperature	365 - 375	°C
Middle - Zone 2 Temperature	355 - 365	°C
Rear - Zone 1 Temperature	345 - 355	°C
Mold Temperature	120 - 150	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	60 - 100	rpm

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