LNP™ THERMOCOMP™ Compound EC006E

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound EC-1006 EM
Product reorder name: EC006E

LNP THERMOCOMP™ EC006E is a compound based on Polyetherimide resin containing 30% Carbon Fiber. Added features of this material include: Easy Molding, Electrically Conductive

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	2350	kgf/cm²	ASTM D 638
Tensile Strain, break	1.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	237600	kgf/cm²	ASTM D 638
Flexural Stress	3200	kgf/cm²	ASTM D 790
Flexural Modulus	195400	kgf/cm²	ASTM D 790
Tensile Stress, break	215	MPa	ISO 527
Tensile Strain, break	1.3	%	ISO 527
Tensile Modulus, 1 mm/min	18470	MPa	ISO 527
Flexural Stress	306	MPa	ISO 178
Flexural Modulus	20800	MPa	ISO 178
IMPACT			
Instrumented Impact Energy @ peak, 23°C	64	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	34	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	206	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	208	°C	ISO 75/Af
PHYSICAL			
Density	1.394	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.17	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.1	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.5	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.1	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.51	%	ISO 294

(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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PHYSICAL			
Wear Factor Washer	75	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.52	-	ASTM D 3702 Modified
Static COF	0.48	-	ASTM D 3702 Modified
Density	1.39	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.25	%	ISO 62

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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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