



## LNP™ THERMOCOMP™ Compound PDXE98480

### Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound PDX-E-98480 PS

Product reorder name: PDXE98480

LNP THERMOCOMP PDXE98480 is a compound based on Polyetherimide with Proprietary Fillers. Added feature of this grade: Reinforced.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, brk, Type I, 5 mm/min	1830	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.7	%	ASTM D 638
Tensile Modulus, 5 mm/min	153900	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	2590	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	136600	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, break, 5 mm/min	162	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.5	%	ISO 527
Tensile Modulus, 1 mm/min	14220	MPa	ISO 527
Flexural Stress	243	MPa	ISO 178
Flexural Modulus, 2 mm/min	12790	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	50	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	9	cm-kgf/cm	ASTM D 256
Multiaxial Impact	40	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	122	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80°10°4 +23°C	33	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80°10°4 +23°C	8	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL</b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	213	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	208	°C	ASTM D 648
CTE, -30°C to 30°C, flow	2.9E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	9.2E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80°10°4 sp=64mm	213	°C	ISO 75/Bf

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(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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Americas: COMMERCIAL

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>THERMAL</b>			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	208	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.6	-	ASTM D 792
Density	1.6	g/cm <sup>3</sup>	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.12	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.2 - 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.4 - 0.6	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.17	%	ISO 62

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(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
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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