



## LNP™ THERMOCOMP™ Compound 9X94104

### Europe-Africa-Middle East: COMMERCIAL

LNP THERMOCOMP 9X94104 is a compound based on Polyetherimide resin containing Glass Fiber.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, break, 5 mm/min	169	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.5	%	ISO 527
Tensile Modulus, 1 mm/min	14500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	207	MPa	ISO 178
Flexural Strain, break, 2 mm/min	2.2	%	ISO 178
Flexural Modulus, 2 mm/min	10300	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, unnotched 80*10*4 +23°C	30	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	9	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL</b>			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	210	°C	ISO 75/Af
<b>PHYSICAL</b>			
Mold Shrinkage, flow (5)	0.15	%	SABIC Method
Density	1.6	g/cm <sup>3</sup>	ISO 1183
Water Absorption, 23°C/24hrs	0.3	%	ISO 62-1

(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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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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