LNP™ STAT-KON™ Compound Noryl_HMC1010
Americas: COMMERCIAL

LNP STAT-KON NORYL_HMC1010 compound is a 10% Carbon fiber reinforced. Static dissipative. Nonbrominated, nonchlor- nated flame retardant system. UL94 V-1 rated.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	800	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	720	kgf/cm²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1050	kgf/cm²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	70300	kgf/cm²	ASTM D 790
Hardness, Rockwell R	122	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	83	mg/1000cy	ASTM D 1044
IMPACT			
Izod Impact, unnotched, 23°C	24	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	111	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	105	°C	ASTM D 648
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL			
Specific Gravity	1.15	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.05 - 0.15	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.15 - 0.3	%	SABIC Method
ELECTRICAL			
Volume Resistivity	8.E+03	Ohm-cm	ASTM D 257
Surface Resistivity	1.3E+04	Ohm	ASTM D 257
Static Decay, 5000V to <50V	0.01	< seconds	FTMS101B
FLAME CHARACTERISTICS			
UL Recognized, 94V-1 Flame Class Rating (3)	2	mm	UL 94

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UL Recognized, 94-5VA Rating (3)	2	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	90 - 95	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	255 - 280	°C
Nozzle Temperature	255 - 280	°C
Front - Zone 3 Temperature	245 - 280	°C
Middle - Zone 2 Temperature	230 - 275	°C
Rear - Zone 1 Temperature	220 - 270	°C
Mold Temperature	65 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.038 - 0.051	mm