



LNP™ STAT-KON™ Compound Noryl_NC2525
Americas: COMMERCIAL

LNP STAT-KON NORYL_NC2525 compound is a 25% CFR PPE+PS. Highly conductive. High heat. May be added to similar material/regrind to add some conductivity to the blend.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1080	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1080	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Modulus, 5 mm/min	210900	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1510	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	161700	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	17	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	92	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	179	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	177	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	170	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.8E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.08E-04	1/°C	ASTM E 831
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	0.4 - 0.6	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.45 - 0.65	%	SABIC Method
Melt Flow Rate, 300°C/5.0 kgf	15.3	g/10 min	ASTM D 1238
ELECTRICAL			
Volume Resistivity	0.E+00	Ohm-cm	ASTM D 257
Surface Resistivity	1.E+03	Ohm	ASTM D 257
Static Decay, 5000V to <50V	0.01	< seconds	FTMS101B



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	110 - 120	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	305 - 335	°C
Nozzle Temperature	305 - 335	°C
Front - Zone 3 Temperature	300 - 335	°C
Middle - Zone 2 Temperature	300 - 325	°C
Rear - Zone 1 Temperature	295 - 320	°C
Mold Temperature	95 - 130	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	50 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.038 - 0.051	mm