

LNP* Thermocomp* Compound ZX06323

Asia Pacific: COMMERCIAL

This material is mineral filled PPO grade with high dielectric constant and low loss tangent

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	0	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	550	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	0	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4.2	%	ASTM D 638
Tensile Modulus, 5 mm/min	42200	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1040	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1040	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	40100	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	0	MPa	ISO 527
Tensile Stress, break, 5 mm/min	54	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	0	%	ISO 527
Tensile Strain, break, 5 mm/min	4.7	%	ISO 527
Tensile Modulus, 1 mm/min	4080	MPa	ISO 527
Flexural Modulus, 2 mm/min	4390	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	29	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	20	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	122	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	122	°C	ISO 75/Af
PHYSICAL			
Density	1.95	g/cm ³	ASTM D 792

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PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.64	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.56	%	ASTM D 955
Density	1.95	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 300°C/5.0 kg	8	cm ³ /10 min	ISO 1133
ELECTRICAL			
Dissipation Factor, 900MHz	0.003	-	ASTM D 150
Relative Permittivity, 900MHz	6.4	-	ASTM D 2520 - Mth B

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	105	°C
Drying Time	3 - 5	hrs
Melt Temperature	295 - 305	°C
Nozzle Temperature	290 - 295	°C
Front - Zone 3 Temperature	300 - 305	°C
Middle - Zone 2 Temperature	290 - 295	°C
Rear - Zone 1 Temperature	280 - 285	°C
Mold Temperature	90	°C
Back Pressure	9	MPa
Screw Speed	100	rpm