

LNP* Thermocomp* Compound ZWM2411

Asia Pacific: COMMERCIAL

Modified PPO*, 30% mineral filled product, V-1@1.5mm, HDT 125degC, low warpage product, BK color only

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	710	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	7	%	ASTM D 638
Tensile Modulus, 5 mm/min	0	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1100	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	53800	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	0	MPa	ISO 527
Tensile Stress, break, 5 mm/min	0	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	0	%	ISO 527
Tensile Strain, break, 5 mm/min	0	%	ISO 527
Tensile Modulus, 1 mm/min	0	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	0	MPa	ISO 178
Flexural Modulus, 2 mm/min	0	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	2	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	0	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	0	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	0	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	0	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	0	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	0	°C	ASTM D 1525

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THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	126	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.1E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	0.E+00	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	0.E+00	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	0	°C	ISO 306
Vicat Softening Temp, Rate B/120	0	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	0	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.33	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 - 0.5	%	SABIC Method
Melt Flow Rate, 300°C/2.16 kgf	15	g/10 min	ASTM D 1238
Density	0	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0	%	ISO 62
Melt Volume Rate, MVR at 220°C/5.0 kg	0	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Compliant, 94V-1 Flame Class Rating (3)(4)	1.5	mm	UL 94 by GE

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	295 - 315	°C
Front - Zone 3 Temperature	280 - 315	°C
Middle - Zone 2 Temperature	270 - 310	°C
Rear - Zone 1 Temperature	260 - 305	°C
Mold Temperature	75 - 105	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%