



LNP™ STAT-KON™ Compound EX03319C

Asia Pacific: COMMERCIAL

LNP STAT-KON EX03319C is a polyetherimide compound reinforced with carbon fiber for good stiffness, dimension stability and has extremely high level of cleanliness for the most demanding application. A unique feature of this material is its low non-volatile residue (NVR). This compound is manufactured using LNP CCS Technology.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	2280	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	173000	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	2370	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	118200	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	36	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	22	kJ/m ²	ISO 179/1eU
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	205	°C	ASTM D 648
PHYSICAL			
Density	1.351	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.05 - 0.15	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.3 - 0.45	%	ASTM D 955
ELECTRICAL			
Volume Resistivity	5.E+03 - 5.E+06	Ohm-cm	ASTM D 257
Surface Resistivity	5.E+03 - 5.E+05	Ohm	ASTM D 257
Static Decay, 5000V to <50V	0.1	< seconds	FTMS101B





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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	150	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	350 - 380	°C
Nozzle Temperature	345 - 380	°C
Front - Zone 3 Temperature	345 - 380	°C
Middle - Zone 2 Temperature	340 - 380	°C
Rear - Zone 1 Temperature	330 - 380	°C
Mold Temperature	135 - 165	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

