

LNP™ COLORCOMP™ EX12304C compound

Polyether Imide

SABIC Innovative Plastics Asia Pacific

Message:

LNP COLORCOMP EX12304C is an unfilled polyetherimide clean compound with extremely high level of cleanliness for the most demanding application. This compound is manufactured using LNP CCS technology.

General Information			
UL YellowCard	E207780-102010009		
Features	Low (to None) Ion Content		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	18	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/5.0 kg)	25.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	3580	MPa	ASTM D638
--	3200	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	110	MPa	ASTM D638
Yield	105	MPa	ISO 527-2/5
Break ³	105	MPa	ASTM D638
Break	85.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	7.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/5
Break ⁵	60	%	ASTM D638
Break	60	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	3420	MPa	ASTM D790
-- ⁷	3300	MPa	ISO 178
Flexural Stress			
--	160	MPa	ISO 178
Yield, 50.0 mm Span ⁸	174	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	32	J/m	ASTM D256
23°C ⁹	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact (23°C)	1300	J/m	ASTM D4812

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 6.40 mm	199	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	193	°C	ISO 75-2/Af
Vicat Softening Temperature	212	°C	ISO 306/B120
CLTE - Flow (-20 to 150°C)	5.6E-5	cm/cm/°C	ASTM E831
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	4.0 to 6.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	332 to 399	°C	
Middle Temperature	338 to 399	°C	
Front Temperature	343 to 399	°C	
Nozzle Temperature	343 to 399	°C	
Processing (Melt) Temp	349 to 399	°C	
Mold Temperature	135 to 163	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.025 to 0.076	mm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*4		
10.	80*10*4 mm		

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