

LNP™ THERMOCOMP™ JF004L compound

Polyethersulfone

SABIC Innovative Plastics

Message:

LNP THERMOCOMP JF004L is a compound is based on Polyethersulfone containing 20% Glass Fiber. Characteristics of this grade is: Low Extractible

Also known as: LNP* THERMOCOMP* Compound JF-1004 LE

Product reorder name: JF004L

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Low Extractables		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.54	g/cm ³	
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Molding Shrinkage			ASTM D955
Flow : 24 hr	0.30 to 0.60	%	
Across Flow : 24 hr	0.50 to 0.70	%	
Water Absorption			
24 hr, 50% RH	0.37	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.55	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6360	MPa	ASTM D638
--	6650	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	98.9	MPa	ASTM D638
Yield	94.4	MPa	ISO 527-2/5
Break ³	98.6	MPa	ASTM D638
Break	93.6	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.7	%	ASTM D638
Yield	2.1	%	ISO 527-2/5
Break ⁵	2.9	%	ASTM D638
Break	2.1	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	6300	MPa	ASTM D790
-- ⁷	6310	MPa	ISO 178
Flexural Stress			
--	149	MPa	ISO 178

--	149	MPa	ISO 178
Yield, 50.0 mm Span ⁸	152	MPa	ASTM D790
Break, 50.0 mm Span ⁹	152	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	50	J/m	ASTM D256
23°C ¹⁰	5.3	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	560	J/m	ASTM D4812
23°C ¹¹	32	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	11.0	J	ASTM D3763
--	2.64	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	216	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	216	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	211	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	210	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	121 to 149	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	343 to 354	°C	
Middle Temperature	360 to 371	°C	
Front Temperature	371 to 382	°C	
Processing (Melt) Temp	354 to 371	°C	
Mold Temperature	138 to 149	°C	
Back Pressure	0.344 to 0.689	MPa	
Screw Speed	60 to 100	rpm	
NOTE			
1.	50 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.	1.3 mm/min		
10.	80*10*4		
11.	80*10*4		

12.	80*10*4 mm
13.	80*10*4 mm

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