

LNP™ THERMOCOMP™ EC006PXQ

compound

Polyether Imide

SABIC Innovative Plastics

Message:

LNP* THERMOCOMP* EC006PXQ is a compound based on Polyetherimide containing 30% Carbon Fiber. Added features include: Electrically Conductive, Easy Molding.

Also known as: LNP* THERMOCOMP* Compound EC006PXQ

Product reorder name: EC006PXQ

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 30% filler by weight		
Features	Conductivity		
	Good formability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (380°C/6.7 kg)	22	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.030 - 0.10	%	ASTM D955
Transverse flow: 24 hours	0.10 - 0.60	%	ASTM D955
Water Absorption (24 hr, 50% RH)	0.11	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	29500	MPa	ASTM D638
--	27600	MPa	ISO 527-2/1
Tensile Strength			
Fracture ²	272	MPa	ASTM D638
Fracture	248	MPa	ISO 527-2/5
Tensile Elongation			
Fracture ³	1.3 - 1.4	%	ASTM D638
Fracture	1.2	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁴	23800	MPa	ASTM D790
-- ⁵	23100	MPa	ISO 178
Flexural Strength ⁶ (Break, 50.0 mm Span)	341	MPa	ASTM D790
Compressive Strength	244	MPa	Internal method
Shear Modulus	4730	MPa	ASTM C273
Shear Strength	128	MPa	ASTM C273

Poisson's Ratio	0.44		ASTM D638
Flexural Strain at Break ⁷	330	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	81	J/m	ASTM D256
Unnotched Izod Impact (23°C)	580	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	12.3	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	195	°C	ASTM D648
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 150°C	7.2E-6	cm/cm/°C	ASTM E831
Lateral: -40 to 150°C	5.8E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+3	ohms	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	120 - 150	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	380 - 400	°C	
Middle Temperature	380 - 400	°C	
Front Temperature	380 - 400	°C	
Processing (Melt) Temp	380 - 400	°C	
Mold Temperature	165 - 180	°C	
Back Pressure	0.300 - 0.700	MPa	
Screw Speed	50 - 100	rpm	
Injection instructions			
Injection Speed: 40 - 70 mm/s			
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	2 mm/min		

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