

LNP™ THERMOCOMP™ Noryl_PCN2910

compound

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

LNP* Thermocomp* Noryl_PCN2910 compound is a 35% Glass/Mica filled. High modulus and tight tolerance molding for the chassis market.

General Information			
UL YellowCard	E121562-221236		
Filler / Reinforcement	Glass\Mica,35% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/5.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.10 to 0.30	%	
Across Flow : 3.20 mm	0.40 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	11400	MPa	ASTM D638
--	10600	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	123	MPa	ASTM D638
Yield	106	MPa	ISO 527-2/5
Break ³	123	MPa	ASTM D638
Break	106	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	1.5	%	ASTM D638
Yield	1.3	%	ISO 527-2/5
Break ⁵	1.5	%	ASTM D638
Break	1.3	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	9790	MPa	ASTM D790
100 mm Span ⁷	8760	MPa	ASTM D790
-- ⁸	9130	MPa	ISO 178
Flexural Stress			
--	160	MPa	ISO 178
Break, 50.0 mm Span ⁹	165	MPa	ASTM D790
Break, 100 mm Span ¹⁰	152	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.4	kJ/m ²	ISO 179/2C
Charpy Unnotched Impact Strength ¹¹ (23°C)	20	kJ/m ²	ISO 179/1eU
Notched Izod Impact			
23°C	59	J/m	ASTM D256
23°C ¹²	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	330	J/m	ASTM D4812
23°C ¹³	14	kJ/m ²	ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	7.12	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	129	°C	ASTM D648
0.45 MPa, Unannealed, 6.40 mm	129	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	123	°C	ASTM D648
1.8 MPa, Unannealed, 6.40 mm	127	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁴	129	°C	ISO 75-2/Af
Vicat Softening Temperature	141	°C	ASTM D1525 ¹⁵
CLTE			ASTM E831
Flow : -40 to 40°C	2.2E-5	cm/cm/°C	
Transverse : -40 to 40°C	4.7E-5	cm/cm/°C	
RTI Elec	65.0	°C	UL 746
RTI Imp	65.0	°C	UL 746
RTI Str	65.0	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.50 mm	V-1		
3.00 mm	V-0		
2.29 mm	5VB		
Injection	Nominal Value	Unit	
Drying Temperature	104 to 110	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	30 to 70	%	
Rear Temperature	260 to 304	°C	
Middle Temperature	271 to 310	°C	
Front Temperature	282 to 316	°C	
Nozzle Temperature	293 to 316	°C	
Processing (Melt) Temp	293 to 316	°C	
Mold Temperature	76.7 to 104	°C	

Back Pressure	0.345 to 0.689	MPa
Screw Speed	20 to 100	rpm
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.	2.6 mm/min	
8.	2.0 mm/min	
9.	1.3 mm/min	
10.	2.6 mm/min	
11.	80*10*4 sp=62mm	
12.	80*10*4	
13.	80*10*4	
14.	80*10*4 mm	
15.	Rate B (120°C/h), Loading 2 (50 N)	

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