

LNP™ LUBRICOMP™ EX03599H compound

Polyether Imide
SABIC Innovative Plastics

Message:

LNP LUBRICOMP EX03599H is a compound based on Polyetherimide resin containing Proprietary Fillers. Added features of this material include: Healthcare, Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound PDX-E-03599 EES HC

Product reorder name: EX03599H

General Information			
Filler / Reinforcement	Proprietary		
Features	Good Wear Resistance		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.28	g/cm ³	ASTM D792
--	1.29	g/cm ³	ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.70	%	ASTM D955
Across Flow : 24 hr	0.80	%	ASTM D955
Across Flow : 24 hr	0.78	%	ISO 294-4
Flow : 24 hr	0.72	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.10	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.25	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	3340	MPa	ASTM D638
--	3190	MPa	ISO 527-2/1
Tensile Strength			
Yield	105	MPa	ASTM D638
Yield	106	MPa	ISO 527-2
Break	88.9	MPa	ASTM D638
Break	98.0	MPa	ISO 527-2
Tensile Elongation			
Yield	7.0	%	ASTM D638
Yield	6.8	%	ISO 527-2
Break	28	%	ASTM D638
Break	9.7	%	ISO 527-2
Flexural Modulus			

--	3480	MPa	ASTM D790
--	3140	MPa	ISO 178
Flexural Strength			
--	152	MPa	ASTM D790
--	112	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.44		
vs. Itself - Static	0.45		
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	48	J/m	ASTM D256
23°C ²	5.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1400	J/m	ASTM D4812
23°C ³	90	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	6.88	J	ASTM D3763
--	2.56	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	190	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	187	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	4.3E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	4.4E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	4.1E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	4.2E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	121 to 149	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	343 to 354	°C	
Middle Temperature	354 to 366	°C	
Front Temperature	366 to 377	°C	
Processing (Melt) Temp	360 to 366	°C	
Mold Temperature	121 to 149	°C	
Back Pressure	0.344 to 0.689	MPa	
Screw Speed	60 to 100	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		

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