

LNP™ COLORCOMP™ EX10304C compound

Polyether Imide

SABIC Innovative Plastics Asia Pacific

Message:

LNP COLORCOMP EX10304C 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	E207780-101339191		
Features	Clean/High Purity		
	Low (to None) Ion Content		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.50 to 0.70	%	
Across Flow : 24 hr	0.50 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3300	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	106	MPa	
Break	95.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	7.0	%	
Break	60	%	
Flexural Modulus ⁴ (50.0 mm Span)	3020	MPa	ASTM D790
Flexural Strength ⁵ (Break, 50.0 mm Span)	160	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	34	J/m	ASTM D256
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)	200	°C	ASTM D648
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. | 1.3 mm/min |
| 5. | 1.3 mm/min |

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