

LNP™ THERMOCOMP™ Noryl_HM4025

compound

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

LNP THERMOCOMP NORYL_HM4025 compound is a 40% Glass/Mineral filled high modulus grade. DTUL 255F (124C). UL94 V-0/V-1/5VA rated in black and gray only (see thicknesses).

General Information			
Filler / Reinforcement	Glass \mineral, 40% filler by weight		
RoHS Compliance	RoHS compliance		
Appearance	Black		
	Grey		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm³	ASTM D792
Molding Shrinkage			Internal method
Flow: 3.20mm	0.15	%	Internal method
Transverse flow: 3.20mm	0.25	%	Internal method
Water Absorption (24 hr)	0.060	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	90		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	127	MPa	ASTM D638
Tensile Elongation ² (Yield)	1.5	%	ASTM D638
Flexural Modulus ³ (100 mm Span)	9650	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 100 mm Span)	159	MPa	ASTM D790
Poisson's Ratio	0.38		ASTM D638
Coefficient of Friction			ASTM D1894
With steel-static	0.42		ASTM D1894
With Self-Static	0.44		ASTM D1894
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	35.0	mg	ASTM D1044
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	124	°C	ASTM D648
Linear thermal expansion coefficient			ASTM E831

Flow: -40 to 95°C	2.2E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 95°C	3.2E-5	cm/cm/°C	ASTM E831
RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746
RTI	50.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+17	ohms	ASTM D257
Volume Resistivity	1.0E+17	ohms·cm	ASTM D257
Dielectric Strength (1.60 mm, in Air)	25	kV/mm	ASTM D149
Arc Resistance ⁵	PLC 5		ASTM D495
Comparative Tracking Index (CTI)	PLC 4		UL 746
High Amp Arc Ignition (HAI)	PLC 4		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 4		UL 746
Hot-wire Ignition (HWI)	PLC 0		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.47 mm	V-1		UL 94
3.00 mm	V-0		UL 94
2.51 mm	5VA		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	104 - 110	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	30 - 70	%	
Rear Temperature	260 - 304	°C	
Middle Temperature	271 - 310	°C	
Front Temperature	282 - 316	°C	
Nozzle Temperature	293 - 316	°C	
Processing (Melt) Temp	293 - 316	°C	
Mold Temperature	76.7 - 104	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	20 - 100	rpm	
NOTE			
1.	Type 1, 5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	2.6 mm/min		
4.	2.6 mm/min		
5.	Tungsten electrode		

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