

LNP™ THERMOCOMP™ 9X02540 compound

Polycarbonate + PET

SABIC Innovative Plastics

Message:

LNP THERMOCOMP PDX-02540 is a compound based on a PET+PC Blend containing Proprietary Filler(s). Added feature of this grade is: Flame Retardant.

Also known as: LNP* THERMOCOMP* Compound PDX-02540

Product reorder name: 9X02540

General Information			
UL YellowCard	E121562-101284697		
Filler / Reinforcement	Proprietary		
Features	Flame Retardant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.47	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	-9.0E-3 to -7.0E-3	%	
Across Flow : 24 hr	0.30 to 0.50	%	
Water Absorption			
24 hr, 50% RH	0.10	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.14	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	7660	MPa	ASTM D638
--	7240	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	108	MPa	ASTM D638
Yield	103	MPa	ISO 527-2/5
Break ³	108	MPa	ASTM D638
Break	103	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.2	%	ASTM D638
Yield	2.2	%	ISO 527-2/5
Break ⁵	2.2	%	ASTM D638
Break	2.2	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	7030	MPa	ASTM D790
-- ⁷	6540	MPa	ISO 178
Flexural Stress			
--	149	MPa	ISO 178
Yield, 50.0 mm Span ⁸	149	MPa	ASTM D790

Break, 50.0 mm Span ⁹	153	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	51	J/m	ASTM D256
23°C ¹⁰	6.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	560	J/m	ASTM D4812
23°C ¹¹	39	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	13.6	J	ASTM D3763
--	1.40	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	130	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	133	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	122	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	120	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	293 to 304	°C	
Middle Temperature	310 to 321	°C	
Front Temperature	321 to 332	°C	
Processing (Melt) Temp	304 to 327	°C	
Mold Temperature	82.2 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 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.	2.0 mm/min		
8.	1.3 mm/min		
9.	1.3 mm/min		
10.	80*10*4		
11.	80*10*4		
12.	80*10*4 mm		
13.	80*10*4 mm		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

