

LNP™ THERMOCOMP™ EX06430H compound

Polyether Imide

SABIC Innovative Plastics

Message:

LNP THERMOCOMP EX06430H is a compound based on Polyetherimide resin containing Proprietary Filler(s). Added feature of this grade is: Healthcare.

Also known as: LNP* THERMOCOMP* Compound EX06430H

Product reorder name: EX06430H

General Information			
Filler / Reinforcement	Proprietary		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34 to 1.40	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.70	%	
Across Flow : 24 hr	0.80	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	3660	MPa	ASTM D638
--	3500	MPa	ISO 527-2/1
Tensile Strength			
Yield	110	MPa	ASTM D638
Yield	106	MPa	ISO 527-2
Break	90.3	MPa	ASTM D638
Break	90.6	MPa	ISO 527-2
Tensile Elongation			
Yield	6.7	%	ASTM D638
Yield	6.0	%	ISO 527-2
Break	14	%	ASTM D638
Break	11	%	ISO 527-2
Flexural Modulus			
--	3670	MPa	ASTM D790
--	3500	MPa	ISO 178
Flexural Stress	133	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	48	J/m	ASTM D256
23°C ²	5.1	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1400	J/m	ASTM D4812

23°C ³	74	kJ/m ²	ISO 180/1U
Instrumented Dart Impact (23°C, Energy at Peak Load)	10.9	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	196	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	195	°C	ISO 75-2/Af
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		
4.	80*10*4 mm		

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