

LNP™ THERMOCOMP™ LF004E compound

Polyetheretherketone

SABIC Innovative Plastics

Message:

LNP THERMOCOMP LF004E is a compound based on Polyetheretherketone resin containing 20% Glass Fiber. Added features of this material include: Easy Molding.

Also known as: LNP* THERMOCOMP* Compound LF-1004 EM

Product reorder name: LF004E

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Good Moldability		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
	1.44		
Specific Gravity	1.45	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.71	%	
Across Flow : 24 hr	1.2	%	
Water Absorption			
24 hr, 50% RH	0.090	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	8730	MPa	ASTM D638
--	8620	MPa	ISO 527-2/1
Tensile Strength			
Break ²	147	MPa	ASTM D638
Break	124	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.3	%	ASTM D638
Break	1.7	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	8090	MPa	ASTM D790
-- ⁵	7720	MPa	ISO 178
Flexural Stress			
--	222	MPa	ISO 178
Break, 50.0 mm Span ⁶	228	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	42	J/m	ASTM D256
23°C ⁷	4.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	480	J/m	ASTM D4812
23°C ⁸	30	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	6.14	J	ASTM D3763
--	1.54	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	337	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	335	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	320	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	305	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	2.8E-5	cm/cm/°C	
Transverse : -30 to 30°C	4.5E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	370 to 380	°C	
Middle Temperature	380 to 400	°C	
Front Temperature	380 to 400	°C	
Mold Temperature	175 to 190	°C	
Back Pressure	0.300 to 0.700	MPa	
Screw Speed	60 to 100	rpm	
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.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		
10.	80*10*4 mm		

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