

LNP™ THERMOCOMP™ 9X02841 compound

Polycarbonate + PBT

SABIC Innovative Plastics

Message:

LNP THERMOCOMP 9X02841 is a PBT/Polycarbonate blend containing proprietary fillers.

Also known as: LNP* THERMOCOMP* Compound PDX-02841

Product reorder name: 9X02841

General Information			
Filler / Reinforcement	Proprietary		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage	ASTM D955		
Flow : 24 hr	0.40 to 0.60	%	
Across Flow : 24 hr	0.60 to 0.80	%	
Water Absorption			
24 hr, 50% RH	0.090	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.14	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5120	MPa	ASTM D638
--	4880	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	83.0	MPa	ASTM D638
Yield	80.0	MPa	ISO 527-2/5
Break ³	83.0	MPa	ASTM D638
Break	80.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.8	%	ASTM D638
Yield	2.6	%	ISO 527-2/5
Break ⁵	2.8	%	ASTM D638
Break	2.6	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	4600	MPa	ASTM D790
-- ⁷	4480	MPa	ISO 178
Flexural Stress			
--	115	MPa	ISO 178
Yield, 50.0 mm Span ⁸	127	MPa	ASTM D790
Break, 50.0 mm Span ⁹	123	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	78	J/m	ASTM D256
23°C ¹⁰	7.6	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	520	J/m	ASTM D4812
23°C ¹¹	31	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	16.8	J	ASTM D3763
--	4.50	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	141	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	140	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	115	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	115	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	4.1E-5	cm/cm/°C	
Transverse : -30 to 30°C	6.3E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	221 to 232	°C	
Middle Temperature	243 to 254	°C	
Front Temperature	260 to 271	°C	
Processing (Melt) Temp	238 to 266	°C	
Mold Temperature	82.2 to 98.9	°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		

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