

LNP™ THERMOCOMP™ LX09409 compound

Polyetheretherketone
SABIC Innovative Plastics

Message:

LNP* THERMOCOMP* LX09409 is a compound based on Polyetheretherketone resin containing proprietary fillers.
Also known as: LNP* THERMOCOMP* Compound LX09409
Product reorder name: LX09409

General Information			
Filler / Reinforcement	Proprietary		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.52	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.76	%	
Across Flow : 24 hr	1.1	%	
Water Absorption			
24 hr, 50% RH	0.070	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.070	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	8310	MPa	ASTM D638
--	7950	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	111	MPa	ASTM D638
Break ³	110	MPa	ASTM D638
Break	112	MPa	ISO 527-2/5
Tensile Elongation			
Break ⁴	2.8	%	ASTM D638
Break	2.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁵	7080	MPa	ASTM D790
-- ⁶	6980	MPa	ISO 178
Flexural Stress			
--	180	MPa	ISO 178
Break, 50.0 mm Span ⁷	174	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	86	J/m	ASTM D256
23°C ⁸	7.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			

23°C	700	J/m	ASTM D4812
23°C ⁹	42	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	7.80	J	ASTM D3763
--	4.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	327	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	306	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	238	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	168	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	2.6E-5	cm/cm/°C	
Transverse : -30 to 30°C	4.2E-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.	Type I, 5.0 mm/min		
5.	1.3 mm/min		
6.	2.0 mm/min		
7.	1.3 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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