

LNP™ THERMOCOMP™ UX08325 compound

Polyphthalamide

SABIC Innovative Plastics Asia Pacific

Message:

LNP THERMOCOMP UX08325 is PPA base glass fiber filled compounds, good for LDS (Laser direct structuring) application. Additional feature is high heat.

General Information			
UL YellowCard	E207780-101334270		
Filler / Reinforcement	Glass Fiber		
Features	High Heat Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.55	g/cm ³	ASTM D792
Molding Shrinkage			Internal Method
Flow	0.42	%	
Across Flow	0.53	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	0.54	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	10900	MPa	ASTM D638
--	11100	MPa	ISO 527-2/1
Tensile Strength			
Break ²	135	MPa	ASTM D638
Break	125	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	1.9	%	ASTM D638
Break	1.6	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	9770	MPa	ASTM D790
-- ⁵	9610	MPa	ISO 178
Flexural Stress			
--	194	MPa	ISO 178
Yield, 50.0 mm Span ⁶	197	MPa	ASTM D790
Break, 50.0 mm Span ⁷	195	MPa	ASTM D790
Flexural Strain at Break ⁸	2.1	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	31	J/m	ASTM D256
23°C ⁹	2.9	kJ/m ²	ISO 180/1A

Unnotched Izod Impact (23°C)	350	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	264	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	262	°C	ISO 75-2/Af
CLTE			ASTM E831
Flow : -40 to 40°C	2.2E-5	cm/cm/°C	
Transverse : -40 to 40°C	5.4E-5	cm/cm/°C	
Electrical	Nominal Value		Test Method
Dielectric Constant (1.00 GHz)	4.20		ASTM D150
Dissipation Factor (1.00 GHz)	0.010		ASTM D150
Injection	Nominal Value	Unit	
Drying Temperature	120 to 150	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15	%	
Rear Temperature	310 to 320	°C	
Middle Temperature	315 to 325	°C	
Front Temperature	325 to 340	°C	
Processing (Melt) Temp	315 to 330	°C	
Mold Temperature	140 to 165	°C	
Back Pressure	0.200 to 0.300	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.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	1.3 mm/min		
8.	2 mm/min		
9.	80*10*4		
10.	80*10*4 mm		

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