

LNP™ STAT-KON™ EX03319C compound

Polyether Imide

SABIC Innovative Plastics Asia Pacific

Message:

LNP STAT-KON EX03319C is a polyetherimide compound reinforced with carbon fiber for good stiffness, dimension stability and has extremely high level of cleanliness for the most demanding application. A unique feature of this material is its low non-volatile residue (NVR). This compound is manufactured using LNP CCS Technology.

General Information			
Filler / Reinforcement	Carbon Fiber		
Features	Good Dimensional Stability		
	Good Stiffness		
	Low (to None) Ion Content		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.050 to 0.15	%	
Across Flow : 24 hr	0.30 to 0.45	%	
Water Absorption (24 hr, 50% RH)	0.20	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	17000	MPa	ASTM D638
Tensile Strength ² (Break)	224	MPa	ASTM D638
Tensile Elongation ³ (Break)	2.3	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	11600	MPa	ASTM D790
Flexural Strength ⁵ (Break, 50.0 mm Span)	233	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶ (23°C)	4.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ⁷ (23°C)	22	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	48	J/m	ASTM D256
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)	205	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	5.0E+3 to 5.0E+5	ohms	ASTM D257
Volume Resistivity	5.0E+3 to 5.0E+6	ohms · cm	ASTM D257
Static Decay ⁸	0.1	sec	FTMS 101B
Injection	Nominal Value	Unit	

Drying Temperature	150	°C
Drying Time	4.0 to 6.0	hr
Drying Time, Maximum	24	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 60	%
Rear Temperature	330 to 380	°C
Middle Temperature	340 to 380	°C
Front Temperature	345 to 380	°C
Nozzle Temperature	345 to 380	°C
Processing (Melt) Temp	350 to 380	°C
Mold Temperature	135 to 165	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm

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. 1.3 mm/min
6. 80*10*4 sp=62mm
7. 80*10*4 sp=62mm
8. 5000V to <50V

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