

LNP™ STAT-KON™ PFD04ES compound

Polyamide 6

SABIC Innovative Plastics Europe

Message:

LNP STAT-KON PFD04ES is a compound based on PA 6 resin containing Carbon Powder, Glass Fiber. Added features include: Electrically Conductive, Easy Molding, Heat Stabilized.

Also known as: LNP* STAT-KON* Compound PF EM

Product reorder name: PFD04ES

General Information			
Filler / Reinforcement	Glass\Carbon Powder		
Additive	Heat Stabilizer		
Features	Electrically Conductive		
	Good Moldability		
	Heat Stabilized		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.32	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.40 to 0.60	%	Internal Method
Water Absorption (23°C, 24 hr)	1.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7000	MPa	ISO 527-2/1
Tensile Stress (Yield)	107	MPa	ISO 527-2/5
Tensile Strain (Break)	2.6	%	ISO 527-2/5
Flexural Modulus ¹	5900	MPa	ISO 178
Flexural Stress	152	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	50	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	214	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	195	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	3.5E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.1E-4	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+4 to 1.0E+6	ohms	ASTM D257
Injection	Nominal Value	Unit	

Drying Temperature	82.2	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.15 to 0.25	%
Rear Temperature	249 to 260	°C
Middle Temperature	266 to 277	°C
Front Temperature	277 to 288	°C
Processing (Melt) Temp	266 to 277	°C
Mold Temperature	82.2 to 93.3	°C
Back Pressure	0.344 to 0.689	MPa
Screw Speed	30 to 60	rpm

NOTE

- | | |
|----|------------|
| 1. | 2.0 mm/min |
| 2. | 80*10*4 |
| 3. | 80*10*4 |
| 4. | 80*10*4 mm |

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