

LNP™ THERMOCOMP™ ZX06323 compound

Polyphenylene Ether + PS

SABIC Innovative Plastics Asia Pacific

Message:

This material is mineral filled PPO grade with high dielectric constant and low loss tangent

General Information			
UL YellowCard	E207780-101284064		
Filler / Reinforcement	Mineral		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.95	g/cm ³	ASTM D792, ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/5.0 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.64	%	
Across Flow : 24 hr	0.56	%	
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4140	MPa	ASTM D638
--	4090	MPa	ISO 527-2/1
Tensile Strength			
Break ²	54.0	MPa	ASTM D638
Break	54.0	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	4.2	%	ASTM D638
Break	4.7	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	3940	MPa	ASTM D790
-- ⁵	4390	MPa	ISO 178
Flexural Strength ⁶			
Yield, 50.0 mm Span	102	MPa	
Break, 50.0 mm Span	102	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	47	J/m	ASTM D256
23°C ⁷	5.4	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	290	J/m	ASTM D4812

23°C ⁸	21	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	122	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁹	123	°C	ISO 75-2/Af
Electrical	Nominal Value		Test Method
Dielectric Constant ¹⁰ (0.900 GHz)	6.40		ASTM D2520
Dissipation Factor (0.900 GHz)	3.0E-3		ASTM D150
Injection	Nominal Value	Unit	
Drying Temperature	105	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	280 to 285	°C	
Middle Temperature	290 to 295	°C	
Front Temperature	300 to 305	°C	
Nozzle Temperature	290 to 295	°C	
Processing (Melt) Temp	295 to 305	°C	
Mold Temperature	90.0	°C	
Back Pressure	9.00	MPa	
Screw Speed	100	rpm	
NOTE			
1.	5.0 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.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		
10.	Method B		

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