

LNP™ THERMOCOMP™ Noryl_HM4025

compound

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

LNP* Thermocomp* Noryl_HM4025 compound is a 40% Glass/Mineral filled high modulus grade. DTUL 255F (124C). UL94 V-0/V-1/5VA rated in black and gray only (see thicknesses).

General Information			
UL YellowCard	E121562-221164		
Filler / Reinforcement	Glass\Mineral,40% Filler by Weight		
Appearance	Black		
	Grey		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.15	%	
Across Flow : 3.20 mm	0.25	%	
Water Absorption (24 hr)	0.060	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	90		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	127	MPa	ASTM D638
Tensile Elongation ² (Yield)	1.5	%	ASTM D638
Flexural Modulus ³ (100 mm Span)	9650	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 100 mm Span)	159	MPa	ASTM D790
Poisson's Ratio	0.38		ASTM D638
Coefficient of Friction			ASTM D1894
vs. Itself - Static	0.44		
vs. Steel - Static	0.42		
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	35.0	mg	ASTM D1044
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	124	°C	ASTM D648
CLTE			ASTM E831

Flow : -40 to 95°C	2.2E-5	cm/cm/°C	
Transverse : -40 to 95°C	3.2E-5	cm/cm/°C	
RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746
RTI Str	50.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+17	ohms	ASTM D257
Volume Resistivity	1.0E+17	ohms·cm	ASTM D257
Dielectric Strength (1.60 mm, in Air)	25	kV/mm	ASTM D149
Arc Resistance ⁵	PLC 5		ASTM D495
Comparative Tracking Index (CTI)	PLC 4		UL 746
High Amp Arc Ignition (HAI)	PLC 4		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 4		UL 746
Hot-wire Ignition (HWI)	PLC 0		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.47 mm	V-1		
3.00 mm	V-0		
2.51 mm	5VA		
Injection	Nominal Value	Unit	
Drying Temperature	104 to 110	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	30 to 70	%	
Rear Temperature	260 to 304	°C	
Middle Temperature	271 to 310	°C	
Front Temperature	282 to 316	°C	
Nozzle Temperature	293 to 316	°C	
Processing (Melt) Temp	293 to 316	°C	
Mold Temperature	76.7 to 104	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	20 to 100	rpm	
NOTE			
1.	Type I, 5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	2.6 mm/min		
4.	2.6 mm/min		
5.	Tungsten Electrode		

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