

LNP™ THERMOCOMP™ PDXE98480

compound

Polyether Imide

SABIC Innovative Plastics

Message:

LNP THERMOCOMP PDXE98480 is a compound based on Polyetherimide with Proprietary Fillers. Added feature of this grade: Reinforced.

Also known as: LNP* THERMOCOMP* Compound PDX-E-98480 PS

Product reorder name: PDXE98480

General Information			
Filler / Reinforcement	Proprietary		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.20 to 0.40	%	
Across Flow : 24 hr	0.40 to 0.60	%	
Water Absorption			
24 hr, 50% RH	0.12	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.17	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	15100	MPa	ASTM D638
--	14200	MPa	ISO 527-2/1
Tensile Strength			
Break ²	180	MPa	ASTM D638
Break	162	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	1.7	%	ASTM D638
Break	1.5	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	13400	MPa	ASTM D790
-- ⁵	12800	MPa	ISO 178
Flexural Stress			
--	243	MPa	ISO 178
Break, 50.0 mm Span ⁶	254	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	92	J/m	ASTM D256

23°C ⁷	8.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	500	J/m	ASTM D4812
23°C ⁸	33	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	12.0	J	ASTM D3763
--	4.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	213	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	213	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	208	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	208	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	2.9E-5	cm/cm/°C	
Transverse : -30 to 30°C	9.2E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121 to 149	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	343 to 354	°C	
Middle Temperature	354 to 366	°C	
Front Temperature	366 to 377	°C	
Processing (Melt) Temp	360 to 366	°C	
Mold Temperature	121 to 149	°C	
Back Pressure	0.344 to 0.689	MPa	
Screw Speed	60 to 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.	80*10*4 mm		

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