

LNP STAT-KON Noryl_HMC1010 compound

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

LNP STAT-KON HMC1010 compound is a 10% Carbon fiber reinforced. Static dissipative. Nonbrominated, nonchlorinated flame retardant system. UL94 V-1 rated.

General Information			
Filler / Reinforcement	Carbon Fiber, 10% Filler by Weight		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.050 to 0.15	%	
Across Flow : 3.20 mm	0.15 to 0.30	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	79.3	MPa	
Break	71.0	MPa	
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Flexural Modulus ³ (100 mm Span)	6890	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 100 mm Span)	103	MPa	ASTM D790
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	83.0	mg	ASTM D1044
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	69	J/m	ASTM D256
Unnotched Izod Impact (23°C)	240	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	111	°C	
1.8 MPa, Unannealed, 6.40 mm	105	°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	1.3E+4	ohms	ASTM D257
Volume Resistivity	8.0E+3	ohms·cm	ASTM D257
Static Decay ⁵	10	msec	FTMS 101B
Flammability	Nominal Value	Unit	Test Method

V-1

Flame Rating (2.01 mm) 5VA UL 94

Injection	Nominal Value	Unit
Drying Temperature	87.8 to 93.3	°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	221 to 271	°C
Middle Temperature	232 to 277	°C
Front Temperature	243 to 282	°C
Nozzle Temperature	254 to 282	°C
Processing (Melt) Temp	254 to 282	°C
Mold Temperature	65.6 to 87.8	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	20 to 100	rpm
Vent Depth	0.038 to 0.051	mm

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. 5000V to <50V

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