

LNP™ THERMOCOMP™ ZF004 compound

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

LNP THERMOCOMP ZF004 is a compound based on PPO resin containing 20% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound ZF-1004

Product reorder name: ZF004

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.10 to 0.30	%	
Across Flow : 24 hr	0.30 to 0.50	%	
Water Absorption			
24 hr, 50% RH	0.090	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.090	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6570	MPa	ASTM D638
--	6510	MPa	ISO 527-2/1
Tensile Strength			
Break ²	80.1	MPa	ASTM D638
Break	79.4	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	1.9	%	ASTM D638
Break	1.9	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	6410	MPa	ASTM D790
-- ⁵	6270	MPa	ISO 178
Flexural Stress			
--	121	MPa	ISO 178
Break, 50.0 mm Span ⁶	118	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	70	J/m	ASTM D256
23°C ⁷	8.4	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	390	J/m	ASTM D4812

23°C ⁸	31	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	12.5	J	ASTM D3763
--	2.80	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	138	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	137	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	131	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	131	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	6.8E-5	cm/cm/°C	
Transverse : -30 to 30°C	5.4E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Rear Temperature	277 to 288	°C	
Middle Temperature	288 to 299	°C	
Front Temperature	299 to 310	°C	
Processing (Melt) Temp	299 to 304	°C	
Mold Temperature	82.2 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 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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