

LNP™ THERMOCOMP™ 4X08423 compound

Perfluoroalkoxy

SABIC Innovative Plastics

Message:

LNP THERMOCOMP 4X08423 is a compound based on PFA resin containing Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound 4X08423

Product reorder name: 4X08423

General Information			
Filler / Reinforcement	Glass Fiber		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	2.19	g/cm ³	
--	2.20	g/cm ³	
Molding Shrinkage			ASTM D955
Flow : 24 hr	2.0 to 4.0	%	
Across Flow : 24 hr	2.0 to 4.0	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	0.010	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4670	MPa	ASTM D638
--	4610	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	40.0	MPa	ASTM D638
Yield	40.0	MPa	ISO 527-2/5
Break ³	36.0	MPa	ASTM D638
Break	39.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	3.3	%	ASTM D638
Yield	3.3	%	ISO 527-2/5
Break ⁵	3.6	%	ASTM D638
Break	3.4	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	3300	MPa	ASTM D790
-- ⁷	4380	MPa	ISO 178
Flexural Stress			
--	60.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	49.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	260	J/m	ASTM D256
23°C ⁹	23	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	590	J/m	ASTM D4812
23°C ¹⁰	45	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	10.9	J	ASTM D3763
--	4.80	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	297	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	259	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	243	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	158	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	5.2E-5	cm/cm/°C	
Transverse : -30 to 30°C	8.9E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	4.0	hr	
Drying Time, Maximum	4.0	hr	
Hopper Temperature	43.0	°C	
Rear Temperature	360	°C	
Middle Temperature	360	°C	
Front Temperature	360	°C	
Nozzle Temperature	366	°C	
Processing (Melt) Temp	360	°C	
Mold Temperature	149	°C	
Back Pressure	3.50	MPa	
Screw Speed	60	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*4		
10.	80*10*4		

11.	80*10*4 mm
12.	80*10*4 mm

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