

LNP™ KONDUIT™ OX10324 compound

Polyphenylene Sulfide
SABIC Innovative Plastics Asia Pacific

Message:

LNP KONDUIT* OX10324 is a compound based on PPS resin. Added feature of this grade is: Thermally Conductive.
Also known as: LNP* KONDUIT* Compound OX10324
Product reorder name: OX10324

General Information			
Features	Heat conduction		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.75	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction: 24 hours	0.10 - 0.30	%	ISO 294-4
Flow direction: 24 hours	0.10 - 0.20	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.010	%	Internal method, ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	13500	MPa	ASTM D638
--	14000	MPa	ISO 527-2/1
Tensile Strength			
Fracture ²	49.0	MPa	ASTM D638
Fracture	53.0	MPa	ISO 527-2/5
Tensile Elongation			
Fracture ³	0.60	%	ASTM D638
Fracture	0.60	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁴	15600	MPa	ASTM D790
-- ⁵	13500	MPa	ISO 178
Flexural Stress			
--	73.0	MPa	ISO 178
Fracture, 50.0mm span ⁶	75.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	24	J/m	ASTM D256
23°C ⁷	3.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	70	J/m	ASTM D4812
23°C ⁸	7.0	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	275	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	258	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁹	231	°C	ISO 75-2/Af
Ball Pressure Test (165°C)	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			
Flow: -40 to 40°C	1.3E-5	cm/cm/°C	ASTM E831
Flow: -30 to 80°C	1.3E-5	cm/cm/°C	ISO 11359-2
Flow: 23 to 80°C	1.4E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	2.5E-5	cm/cm/°C	ASTM E831
Horizontal: -30 to 80°C	2.4E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 80°C	2.4E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity			
-- ¹⁰	3.5	W/m/K	ASTM E1461
-- ¹¹	15	W/m/K	ASTM E1461
-- ¹²	1.3	W/m/K	ISO 22007-2
-- ¹³	18	W/m/K	ISO 22007-2
RTI Elec	130	°C	UL 746
RTI Imp	130	°C	UL 746
RTI	130	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 2.5E+4	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.20 mm)	V-0		UL 94
Glow Wire Ignition Temperature (1.00 mm)	850	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	121 - 149	°C	
Drying Time	4.0	hr	
Suggested Shot Size	50 - 75	%	
Rear Temperature	316 - 343	°C	
Middle Temperature	316 - 343	°C	
Front Temperature	316 - 343	°C	
Processing (Melt) Temp	321 - 349	°C	
Mold Temperature	110 - 150	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	60 - 100	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 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.	through-plane, 10*10*3mm sample
11.	in-plane, ø25*0.4mm disc
12.	through-plane, 60*60*3mm plaque
13.	in-plane, 60*60*3mm plaque

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