



## LNP™ THERMOCOMP™ Compound 9X02841

### Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound PDX-02841

Product reorder name: 9X02841

LNP THERMOCOMP 9X02841 is a PBT/Polycarbonate blend containing proprietary fillers.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	840	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	840	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	52200	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1290	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1250	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	46900	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, yield, 5 mm/min	80	MPa	ISO 527
Tensile Stress, break, 5 mm/min	80	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.6	%	ISO 527
Tensile Strain, break, 5 mm/min	2.6	%	ISO 527
Tensile Modulus, 1 mm/min	4880	MPa	ISO 527
Flexural Stress	115	MPa	ISO 178
Flexural Modulus, 2 mm/min	4480	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	53	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
Multiaxial Impact	45	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	171	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80°10*4 +23°C	31	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80°10*4 +23°C	7	kJ/m <sup>2</sup>	ISO 180/1A



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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>THERMAL</b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	141	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	115	°C	ASTM D 648
CTE, -30°C to 30°C, flow	4.1E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	6.3E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	140	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	115	°C	ISO 75/Af
<b>PHYSICAL</b>			
Density	1.33	g/cm <sup>3</sup>	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.09	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.4 - 0.6	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.6 - 0.8	%	ASTM D 955
Density	1.33	g/cm <sup>3</sup>	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62



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<b>PROCESSING PARAMETERS</b>	<b>TYPICAL VALUE</b>	<b>Unit</b>
<b>Injection Molding</b>		
Drying Temperature	120	°C
Drying Time	4	hrs
Maximum Moisture Content	0.05	%
Melt Temperature	240 - 265	°C
Front - Zone 3 Temperature	260 - 270	°C
Middle - Zone 2 Temperature	245 - 255	°C
Rear - Zone 1 Temperature	220 - 230	°C
Mold Temperature	80 - 100	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm