



LNP™ THERMOCOMP™ Compound 9X02540

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound PDX-02540

Product reorder name: 9X02540

LNP THERMOCOMP PDX-02540 is a compound based on a PET+PC Blend containing Proprietary Filler(s). Added feature of this grade is: Flame Retardant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1100	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1100	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.1	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.1	%	ASTM D 638
Tensile Modulus, 50 mm/min	78000	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1510	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1560	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	71600	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	103	MPa	ISO 527
Tensile Stress, break, 5 mm/min	103	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.1	%	ISO 527
Tensile Strain, break, 5 mm/min	2.1	%	ISO 527
Tensile Modulus, 1 mm/min	7240	MPa	ISO 527
Flexural Stress	149	MPa	ISO 178
Flexural Modulus, 2 mm/min	6530	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	56	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Multiaxial Impact	14	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	138	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	38	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A



LNP™ THERMOCOMP™ Compound 9X02540

Americas: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	130	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	122	°C	ASTM D 648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	133	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	120	°C	ISO 75/Af
PHYSICAL			
Density	1.47	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	-0.01 - -0.01	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.3 - 0.5	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.14	%	ISO 62



LNP™ THERMOCOMP™ Compound 9X02540

Americas: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	305 - 325	°C
Front - Zone 3 Temperature	320 - 330	°C
Middle - Zone 2 Temperature	310 - 320	°C
Rear - Zone 1 Temperature	295 - 305	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm