



LNP™ COLORCOMP™ Compound EX10304C

Asia Pacific: COMMERCIAL

LNP COLORCOMP EX10304C is an unfilled polyetherimide clean compound with extremely high level of cleanliness for the most demanding application. This compound is manufactured using LNP CCS Technology.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1080	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	960	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	33600	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1630	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	30700	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	136	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	200	°C	ASTM D 648
PHYSICAL			
Density	1.27	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.5 - 0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.5 - 0.7	%	ASTM D 955



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	150	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	350 - 400	°C
Nozzle Temperature	345 - 400	°C
Front - Zone 3 Temperature	345 - 400	°C
Middle - Zone 2 Temperature	340 - 400	°C
Rear - Zone 1 Temperature	330 - 400	°C
Mold Temperature	135 - 165	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm