



LNP™ THERMOCOMP™ Compound UX08325

Asia Pacific: COMMERCIAL

LNP THERMOCOMP UX08325 is PPA base glass fiber filled compounds, good for LDS (Laser direct structuring) application. Additional feature is high heat.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1370	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	111000	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	2000	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1980	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	99600	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	125	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.6	%	ISO 527
Tensile Modulus, 1 mm/min	11080	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	194	MPa	ISO 178
Flexural Strain, break, 2 mm/min	2	%	ISO 178
Flexural Modulus, 2 mm/min	9610	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	35	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	2	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	263	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.4E-05	1/°C	ASTM E 831
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	261	°C	ISO 75/Af
PHYSICAL			
Density	1.55	g/cm ³	ASTM D 792
Mold Shrinkage, flow (5)	0.41	%	SABIC Method



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Mold Shrinkage, xflow (5)	0.52	%	SABIC Method
Moisture Absorption (23°C / 50% RH)	0.53	%	ISO 62
ELECTRICAL			
Relative Permittivity, 1 GHz	4.2	-	ASTM D 150
Dissipation Factor, 1 GHz	0.01	-	ASTM D 150



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120 - 150	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15	%
Melt Temperature	315 - 330	°C
Front - Zone 3 Temperature	325 - 340	°C
Middle - Zone 2 Temperature	315 - 325	°C
Rear - Zone 1 Temperature	310 - 320	°C
Mold Temperature	140 - 165	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm