



LNP™ THERMOCOMP™ Compound NORYL_PCN2910
Americas: COMMERCIAL

LNP* Thermocomp* Noryl_PCN2910 compound is a 35% Glass/Mica filled. High modulus and tight tolerance molding for the chassis market.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1250	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1250	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	1.5	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.5	%	ASTM D 638
Tensile Modulus, 5 mm/min	116000	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1680	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 2.6 mm/min, 100 mm span	1540	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	99800	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	89200	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	106	MPa	ISO 527
Tensile Stress, break, 5 mm/min	106	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	1.3	%	ISO 527
Tensile Strain, break, 5 mm/min	1.3	%	ISO 527
Tensile Modulus, 1 mm/min	10600	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	160	MPa	ISO 178
Flexural Stress, break, 2 mm/min	160	MPa	ISO 178
Flexural Modulus, 2 mm/min	9130	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	33	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	72	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	14	kJ/m ²	ISO 180/1U



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IMPACT			
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
Charpy Impact, notched, 23°C	4	kJ/m ²	ISO 179/2C
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	20	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	140	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	129	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	123	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	129	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	126	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.16E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.68E-05	1/°C	ASTM E 831
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	129	°C	ISO 75/Af
Relative Temp Index, Elec	65	°C	UL 746B
Relative Temp Index, Mech w/impact	65	°C	UL 746B
Relative Temp Index, Mech w/o impact	65	°C	UL 746B
PHYSICAL			
Specific Gravity	1.38	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.1 - 0.3	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.4 - 0.6	%	SABIC Method
Melt Flow Rate, 300°C/5.0 kgf	10	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
UL Recognized, 94V-1 Flame Class Rating (3)	1.49	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	2.99	mm	UL 94
UL Recognized, 94-5VB Rating (3)	2.28	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	295 - 315	°C
Front - Zone 3 Temperature	280 - 315	°C
Middle - Zone 2 Temperature	270 - 310	°C
Rear - Zone 1 Temperature	260 - 305	°C
Mold Temperature	75 - 105	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%