



LNP™ THERMOCOMP™ Compound ZX08309

Asia Pacific: COMMERCIAL

This material is mineral filled PPO grade with high dielectric constant and low loss tangent

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Flexural Stress, brk, 1.3 mm/min, 50 mm span	910 - 1010	kgf/cm ²	ASTM D 790
Flexural Modulus, 2 mm/min	3200 - 3500	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	134	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	122	°C	ASTM D 648
PHYSICAL			
Mold Shrinkage, flow, 24 hrs (5)	0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.65	%	ASTM D 955
Density	1.66	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 300°C/5.0 kg	11	cm ³ /10 min	ISO 1133
ELECTRICAL			
Dielectric Constant (Dk), 1.1 GHz	4.4 - 4.6	-	ASTM ES 7-83
Dissipation Factor (Df), 1.1 GHz	0.002 - 0.004	-	ASTM ES 7-83



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	105	°C
Drying Time	3 - 5	hrs
Melt Temperature	295 - 305	°C
Nozzle Temperature	290 - 295	°C
Front - Zone 3 Temperature	300 - 305	°C
Middle - Zone 2 Temperature	290 - 295	°C
Rear - Zone 1 Temperature	280 - 285	°C
Mold Temperature	90	°C
Back Pressure	9	MPa
Screw Speed	100	rpm