



## LNP\* Thermocomp\* Compound ZX06323

### Asia Pacific: COMMERCIAL

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

| TYPICAL PROPERTIES <sup>1</sup>              | TYPICAL VALUE | UNIT                | STANDARD    |
|----------------------------------------------|---------------|---------------------|-------------|
| <b>MECHANICAL</b>                            |               |                     |             |
| Tensile Stress, yld, Type I, 5 mm/min        | 0             | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Stress, brk, Type I, 5 mm/min        | 550           | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Strain, yld, Type I, 5 mm/min        | 0             | %                   | ASTM D 638  |
| Tensile Strain, brk, Type I, 5 mm/min        | 4.2           | %                   | ASTM D 638  |
| Tensile Modulus, 5 mm/min                    | 42200         | kgf/cm <sup>2</sup> | ASTM D 638  |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 1040          | kgf/cm <sup>2</sup> | ASTM D 790  |
| Flexural Stress, brk, 1.3 mm/min, 50 mm span | 1040          | kgf/cm <sup>2</sup> | ASTM D 790  |
| Flexural Modulus, 1.3 mm/min, 50 mm span     | 40100         | kgf/cm <sup>2</sup> | ASTM D 790  |
| Tensile Stress, yield, 5 mm/min              | 0             | MPa                 | ISO 527     |
| Tensile Stress, break, 5 mm/min              | 54            | MPa                 | ISO 527     |
| Tensile Strain, yield, 5 mm/min              | 0             | %                   | ISO 527     |
| Tensile Strain, break, 5 mm/min              | 4.7           | %                   | ISO 527     |
| Tensile Modulus, 1 mm/min                    | 4080          | MPa                 | ISO 527     |
| Flexural Modulus, 2 mm/min                   | 4390          | MPa                 | ISO 178     |
| <b>IMPACT</b>                                |               |                     |             |
| Izod Impact, unnotched, 23°C                 | 29            | cm-kgf/cm           | ASTM D 4812 |
| Izod Impact, notched, 23°C                   | 4             | cm-kgf/cm           | ASTM D 256  |
| Izod Impact, unnotched 80*10*4 +23°C         | 20            | kJ/m <sup>2</sup>   | ISO 180/1U  |
| Izod Impact, notched 80*10*4 +23°C           | 5             | kJ/m <sup>2</sup>   | ISO 180/1A  |
| <b>THERMAL</b>                               |               |                     |             |
| HDT, 1.82 MPa, 3.2mm, unannealed             | 122           | °C                  | ASTM D 648  |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm        | 122           | °C                  | ISO 75/Af   |
| <b>PHYSICAL</b>                              |               |                     |             |
| Density                                      | 1.95          | g/cm <sup>3</sup>   | ASTM D 792  |



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| <b>PHYSICAL</b>                       |               |                         |                     |
| Moisture Absorption, 50% RH, 24 hrs   | 0.1           | %                       | ASTM D 570          |
| Mold Shrinkage, flow, 24 hrs          | 0.64          | %                       | ASTM D 955          |
| Mold Shrinkage, xflow, 24 hrs         | 0.56          | %                       | ASTM D 955          |
| Density                               | 1.95          | g/cm <sup>3</sup>       | ISO 1183            |
| Melt Volume Rate, MVR at 300°C/5.0 kg | 8             | cm <sup>3</sup> /10 min | ISO 1133            |
| <b>ELECTRICAL</b>                     |               |                         |                     |
| Dissipation Factor, 900MHz            | 0.003         | -                       | ASTM D 150          |
| Relative Permittivity, 900MHz         | 6.4           | -                       | ASTM D 2520 - Mth B |



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| PROCESSING PARAMETERS       | TYPICAL VALUE | UNIT |
|-----------------------------|---------------|------|
| <b>Injection Molding</b>    |               |      |
| 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  |