



LNP™ KONDUIT™ Compound OX10324

Americas: COMMERCIAL

Also known as: LNP™ KONDUIT™ Compound OX10324

Product reorder name: OX10324

LNP KONDUIT™ OX10324 is a compound based on PPS resin. Added feature of this grade is: Thermally Conductive.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	490	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	0.6	%	ASTM D 638
Tensile Modulus, 5 mm/min	137600	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	760	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	159000	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	53	MPa	ISO 527
Tensile Strain, break, 5 mm/min	0.6	%	ISO 527
Tensile Modulus, 1 mm/min	14000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	73	MPa	ISO 178
Flexural Modulus, 2 mm/min	13500	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	7	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	2	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	7	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	3	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm	275	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	258	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.32E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	2.5E-05	1/°C	ASTM E 831
Thermal Conductivity through-plane, 60*60*3mm plaque	1.3	W/m-K	ISO 22007-2
Thermal Conductivity in-plane, 60*60*3mm plaque	18	W/m-K	ISO 22007-2
Thermal Conductivity through-plane, 10*10*3mm sample	3.5	W/m-K	ASTM E 1461-07



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THERMAL			
Thermal Conductivity in-plane, ø25*0.4mm disc	15	W/m-K	ASTM E 1461-07
CTE, -30°C to 80°C, flow	1.3E-05	1/°C	ISO 11359-2
CTE, -30°C to 80°C, xflow	2.39E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, flow	1.38E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	2.44E-05	1/°C	ISO 11359-2
Ball Pressure Test, 165°C +/- 2°C	PASSES	-	IEC 60695-10-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	231	°C	ISO 75/Af
Relative Temp Index, Elec	130	°C	UL 746B
Relative Temp Index, Mech w/impact	130	°C	UL 746B
Relative Temp Index, Mech w/o impact	130	°C	UL 746B
PHYSICAL			
Mold Shrinkage, flow, 24 hrs (5)	0.1 - 0.2	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.1 - 0.3	%	ISO 294
Density	1.75	g/cm ³	ISO 1183
Water Absorption, 23°C/24hrs	0.01	%	ISO 62-1
Water Absorption, 23°C/24hrs	0.01	%	SABIC Method
ELECTRICAL			
Surface Resistivity	>2.5E+04	Ohm	ASTM D 257
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.2	mm	UL 94
Glow Wire Ignitability Temperature, 1.0 mm	850	°C	IEC 60695-2-13



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120 - 150	°C
Drying Time	4	hrs
Melt Temperature	320 - 350	°C
Front - Zone 3 Temperature	315 - 345	°C
Middle - Zone 2 Temperature	315 - 345	°C
Rear - Zone 1 Temperature	315 - 345	°C
Mold Temperature	110 - 150	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	60 - 100	rpm
Shot to Cylinder Size	50 - 75	%