

LNP* Thermocomp* Compound 2X03624H Americas: DEVELOPMENTAL

Also known as: PDX-FP-F-03624
Product Reorder Name: 2X03624H

LNP* Thermocomp* 2X03624H is a compound based on FEP resin containing Mineral.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield	13	MPa	ASTM D 638
Tensile Stress, break	NB	MPa	ASTM D 638
Tensile Strain, yield	9.3	%	ASTM D 638
Tensile Strain, break	NB	%	ASTM D 638
Flexural Stress	13	MPa	ASTM D 790
Flexural Modulus	620	MPa	ASTM D 790
Tensile Stress, yield	14	MPa	ISO 527
Tensile Stress, break	NB	MPa	ISO 527
Tensile Strain, yield	7.2	%	ISO 527
Tensile Strain, break	NB	%	ISO 527
Flexural Stress	16	MPa	ISO 178
Flexural Modulus	600	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	NB	J/m	ASTM D 4812
Izod Impact, notched, 23°C	566	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	30	J	ASTM D 3763
Multiaxial Impact	46	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	64	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	53	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.21E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.26E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	1.21E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.28E-04	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	58	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Density	2.23	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	3.9	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	4.5	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	3.89	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	4.49	%	ISO 294
Density	2.22	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.03	%	ISO 62

Source GMD, last updated:09/24/2008

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120 - 150	°C
Drying Time	4	hrs
Melt Temperature	345	°C
Front - Zone 3 Temperature	360 - 370	°C
Middle - Zone 2 Temperature	340 - 350	°C
Rear - Zone 1 Temperature	315 - 325	°C
Mold Temperature	140 - 165	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

Source GMD, last updated:09/24/2008

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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