

LNPTM THERMOCOMPTM COMPOUND NX10302

DESCRIPTION

This is a PC/ABS compound with improved plating, surface and mechanical performance, a good candidate for Laser Direct Structuring applications.

TYPICAL PROPERTY VALUES

Revision 20191216

Tensile Stress, brk, Type I, 5 mm/min 46 MPa ASTM D 638 Tensile Stress, brk, Type I, 5 mm/min 47 MPa ASTM D 638 Tensile Strain, lyd. Type I, 5 mm/min 100 % ASTM D 638 Tensile Strain, lyd. Type I, 5 mm/min 100 % ASTM D 638 Tensile Modulus, 50 mm/min 2480 MPa ASTM D 638 Flexural Strass, lyd. 1,3 mm/min, 50 mm span 79 MPa ASTM D 790 Flexural Modulus, 1,3 mm/min, 50 mm span 9 MPa ASTM D 790 Flexural Modulus, 1,3 mm/min, 50 mm span 9 MPa ASTM D 790 Flexural Modulus, 1,3 mm/min, 50 mm span 9 MPa ASTM D 4812 Look Impact, unnotched, 23°C 80 J/m ASTM D 4812 Coll Impact, unnotched, 23°C 80 J/m ASTM D 4812 Coll Chipac 8.7 MPa ASTM D 4812 CTE, 40°C to 40°C, flow 9 MPa ASTM D 638 CTE, 40°C to 40°C, flow 9 C U. 7468 Relative Temp Index, Elec ¹⁰ 80 C U. 74	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Tensile Stress, brk, Type I, 5 mm/min 47 MPa ASTM D 638 Tensile Strain, brk, Type I, 5 mm/min 42 % ASTM D 638 Tensile Strain, brk, Type I, 5 mm/min 100 % ASTM D 638 Tensile Strain, brk, Type I, 5 mm/min 2480 MPa ASTM D 638 Flexural Stress, brk, 1,3 mm/min, 50 mm span 9 MPa ASTM D 790 Flexural Stress, brk, 1,3 mm/min, 50 mm span 9 MPa ASTM D 790 Flexural Modulus, 1,3 mm/min, 50 mm span 19 MPa ASTM D 790 IMPACT V V V V IMPACT V ASTM D 592 V	MECHANICAL			
Tensile Strain, yld, Type I, 5 mm/min 4.2 % ASTM D 638 Tensile Modulus, 10 mm/min 2480 MPa ASTM D 638 Tensile Modulus, 13 mm/min, 50 mm span 80 MPa ASTM D 790 Flexural Stress, brk, 1.3 mm/min, 50 mm span 79 MPa ASTM D 790 Flexural Stress, brk, 1.3 mm/min, 50 mm span 400 MPa ASTM D 790 IMPACT V J/m ASTM D 4812 Izod Impact, unnotched, 23°C 88 J/m ASTM D 256 THERMAL J/m ASTM D 4812 THERMAL J/m ASTM D 4812 CTE, 40°C to 40°C, flow 8.47±05 1/°C ASTM D 648 CTE, 40°C to 40°C, flow 8.47±05 1/°C ASTM D 648 CTE, 40°C to 40°C, flow 8.47±05 1/°C ASTM D 58 Relative Tenp Index, Mech w/j impact 10 60 °C U. 7468 Relative Tenp Index, Mech w/j impact 10 60 °C U. 7468 Relative Tenp Index, Mech w/j impact 10 60 °C U. 7468 Relative Tenp Index, Mech w/j impact 10<	Tensile Stress, yld, Type I, 5 mm/min	46	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min 100 % May ASTM D 638 Tensile Strain, brk, Type I, 5 mm/min 2480 May ASTM D 790 Flexural Stress, brk, I, 3 mm/min, 50 mm span 79 May ASTM D 790 Flexural Stress, brk, I, 3 mm/min, 50 mm span 2400 Mpa ASTM D 790 IMPACT STM D 790 Mpa ASTM D 790 IMPACT Bog 1/m ASTM D 780 Text Bod Impact, unnotched, 23°C 80 1/m ASTM D 4812 Text Bod Impact, unnotched, 23°C 80 1/m ASTM D 4812 Text Bod Impact, unnotched, 23°C 80 1/m ASTM D 566 TEX BOD TO, 160°C 80 2 ASTM D 566 TEX BOD TO, 160°C 40°C ASTM D 648 ASTM D 648 CEC, 40°C to 40°C, flow 410 2 ME8 31 Relative Temp Index, Mech w/limpact fl 60 2 U.7468 Relative Temp Index, Mech w/limpact fl 2.6 \$ ASTM D 792 Water Absorption, 24 hours 1.26 \$ ASTM D 792	Tensile Stress, brk, Type I, 5 mm/min	47	MPa	ASTM D 638
Tensile Modulus, 50 mm/min 2480 MPa ASTM D 638 Flexural Stress, yld, 1.3 mm/min, 50 mm span 80 MPa ASTM D 790 Flexural Stress, brk, 1.3 mm/min, 50 mm span 79 MPa ASTM D 790 Flexural Modulus, 1.3 mm/min, 50 mm span 400 MPa ASTM D 790 IMPACT User User J/m ASTM D 4812 Isod Impact, unnotched, 23°C 10 1/m ASTM D 4812 Isod Impact, notched, 23°C 10 1/m ASTM D 4812 HERMAL User ASTM D 4812 THERMAL User ASTM D 648 CTE, 40°C to 40°C, flow 10 °C ASTM D 648 CTE, 40°C to 40°C, flow 1,26 ASTM D 648 1 CREditive Temp Index, Electri 60 °C ASTM D 648 CREditive Temp Index, Mech w/Impact 10 °C U.7468 PHYSICAL 2 U.7468 V.7468 PHYSICAL 3 ASTM D 790 ASTM D 790 Water Absorption, 24 hours 1 2 3	Tensile Strain, yld, Type I, 5 mm/min	4.2	%	ASTM D 638
Reward Stress, vid, 1.3 mm/min, 50 mm span 80 MPa ASTM D 790 Reward Modulus, 1.3 mm/min, 50 mm span 79 MPa ASTM D 790 Reward Modulus, 1.3 mm/min, 50 mm span 2400 MPa ASTM D 790 MPACT W MPA ASTM D 4812 Ized Impact, unnotched, 23°C NB J/m ASTM D 4812 Ized Impact, unnotched, 23°C NB J/m ASTM D 698 THERMAL V ASTM D 698 ASTM D 698 CTE, 40°C to 40°C, flow 8.47E-05 1/°C ASTM D 698 CTE, 40°C to 40°C, flow 9.1E-05 1/°C ASTM D 698 Relative Temp Index, Mech W/impact (1) 60 C ASTM D 698 Relative Temp Index, Mech W/impact (1) 1.26 9Cm U.7468 Relative Temp Index, Mech W/impact (1) 1.26 9Cm ² ASTM D 570 Water Absorption, 24 hors 0.2 ASTM D 570 ASTM D 570 Water Absorption, 24 hors 0.6-0.55 3 ASTM D 570 Mold Shrinkage, flow, 24 hrs 0.6-0.55 3 ASTM D 570	Tensile Strain, brk, Type I, 5 mm/min	100	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span 79 MPa ASTM D 790 Flexural Modulus, 1.3 mm/min, 50 mm span 2400 MPa ASTM D 790 IMPACT V V ASTM D 4812 Izod Impact, unnotched, 23°C 600 J/m ASTM D 256 THERMAL V J/m ASTM D 56 THERMAL *** *** ASTM D 648 CTE, 40°C to 40°C, flow 8.47€.05 1/°C ASTM D 638 CTE, 40°C to 40°C, flow 9.16.05 1/°C ASTM E 831 Relative Temp Index, flow, cflow 60 °C MD 481 Relative Temp Index, Mech w/impact (¹) 60 °C U.7468 Relative Temp Index, Mech w/impact (¹) 60 °C U.7468 Relative Temp Index, Mech w/o impact (¹) 1.26 g/cm³ ASTM D 792 Water Absorption, 24 hours 0.01 % ASTM D 792 Water Absorption, 50% RH, 24 hrs 0.02 % ASTM D 570 Mold Shrinkage, flow, 24 hrs 0.02 % ASTM D 955 Mold Volume Rate,	Tensile Modulus, 50 mm/min	2480	MPa	ASTM D 638
MPB	Flexural Stress, yld, 1.3 mm/min, 50 mm span	80	MPa	ASTM D 790
IMPACT Izod Impact, unnotched, 23°C NB J/m ASTM D 4812 Izod Impact, notched, 23°C 600 J/m ASTM D 256 THERMAL THERMAL THERMAL THERMAL SC ASTM D 648 CTE, 40°C to 40°C, flow 8.47605 1/°C ASTM E 831 CTE, 40°C to 40°C, flow 9.1603 1/°C ASTM E 831 Relative Temp Index, Mech w/impact (1) 60 °C UL 7468 Relative Temp Index, Mech w/impact (1) 60 °C UL 7468 Relative Temp Index, Mech w/impact (1) 60 °C UL 7468 Relative Temp Index, Mech w/impact (1) 60 °C UL 7468 Relative Temp Index, Mech w/impact (1) 60 °C UL 7468 Relative Temp Index, Mech w/impact (1) 26 WILL 7468 Relative Temp Index, Mech w/impact (1) 60 9cm ASTM D 95 Will Strinking Mechany (1) 1.26 9cm ASTM D 95 Molt Strinking Mechany (2) 4.5 4.5 4.5 4.5 1.5 4.5 1.5 4.5 </td <td>Flexural Stress, brk, 1.3 mm/min, 50 mm span</td> <td>79</td> <td>MPa</td> <td>ASTM D 790</td>	Flexural Stress, brk, 1.3 mm/min, 50 mm span	79	MPa	ASTM D 790
Ize of Impact, unnotched, 23°C NB J/m ASM D 256 Ize Impact, notched, 23°C 60° J/m ASM D 256 THERMAL HOT, 182 MPa, 3.2mm, unannealed 10° C ASTM D 648 CTE, 40°C to 40°C, flow 91.05 1/°C ASTM E 831 CTE, 40°C to 40°C, flow 91.05 1/°C ASTM E 831 Relative Temp Index, Elec ⁽¹⁾ 60° °C U.746B Relative Temp Index, Mech w/Impact ⁽¹⁾ 60° °C U.746B Relative Temp Index, Mech w/Jo impact ⁽¹⁾ 10° 0 U.746B WERL V U.746B V U.746B Relative Temp Index, Mech w/Jo impact ⁽¹⁾ 60° U.746B V WERL V V V V Molicy Alpha Mech w/Jo impact ⁽¹⁾ 10° ASTM D 570 ASTM D 570 Molicy Shift May 24 In May 25 ASTM D 570 ASTM D 570 ASTM D 570 Molicy Shift May 24 In May 25 ASTM D 570 ASTM D 570	Flexural Modulus, 1.3 mm/min, 50 mm span	2400	MPa	ASTM D 790
Izod Impact, notched, 23°C 600 I/Imm ASTM D 256 THERMAL THERMAL C ASTM D 648 CTE, 40°C to 40°C, flow 8.47E-05 I/°C ASTM E 831 CTE, 40°C to 40°C, flow 9.1E-05 I/°C ASTM E 831 CER, 40°C to 40°C, flow 9.1E-05 I/°C ASTM E 831 Relative Temp Index, Elec ⁽¹⁾ 60 °C UL 7468 Relative Temp Index, Mech w/impact (1) 60 °C UL 746B Relative Temp Index, Mech w/impact (1) 60 °C UL 746B Relative Temp Index, Mech w/impact (1) 60 °C UL 746B Relative Temp Index, Mech w/impact (1) 60 °C UL 746B Relative Temp Index, Mech w/impact (1) 60 °C UL 746B Relative Temp Index, Mech w/impact (1) 60 °C UL 746B Water Absorption, 50% Rh, 24 hrs 0.01 \$1 STM D 570 Mold Shrinkage, flow, 24 hrs 0.5 - 0.56 \$2 ASTM D 955 Melt Volume Rate, MVR at 260°C/5.0 kg 2.74 C EC	IMPACT			
THERMAL HDT, 1.82 MPa, 3.2mm, unannealed 108 °C ASTM D 648 CTE, 40°C to 40°C, flow 8.47E-05 1/°C ASTM E 831 CTE, 40°C to 40°C, xflow 9.1E-05 1/°C ASTM E 831 Relative Temp Index, Elec (¹) 60 °C U.7468 Relative Temp Index, Mech w/impact (¹) 60 °C U.7468 Relative Temp Index, Mech w/o impact (¹) 60 °C U.7468 Relative Temp Index, Mech w/o impact (¹) 60 °C U.7468 Relative Temp Index, Mech w/o impact (¹) 1.26 g/cm³ ASTM D 95 Water Absorption, 24 hours 0.01 % ASTM D 95 Water Absorption, 50% RH, 24 hrs 0.02 % ASTM D 95 Mold Shrinkage, flow, 24 hrs 0.6 – 0.65 % ASTM D 95 Melt Volume Rate, MVR at 260°C/5.0 kg 14 cm³/10 min S0 1133 ELECTRICA 2.74 C EC 60250 Electrical City C C C Electrical City C C C	Izod Impact, unnotched, 23°C	NB	J/m	ASTM D 4812
HDT, 1.82 MPa, 3.2mm, unannealed CTE, 40°C to 40°C, flow 8.47€05 8.47€05 1/°C ASTM E 831 CTE, 40°C to 40°C, xflow 9.1€05 1/°C 1/°C ASTM E 831 ASTM E 831 CTE, 40°C to 40°C, xflow 9.1€05 1/°C 4.57 ME 831 4.58 ME 831 CTE, 40°C to 40°C, xflow 10.7468 Relative Temp Index, Elec (¹) 60 60 60 70 10.17468 Relative Temp Index, Mech w/impact (¹) 60 70 10.17468 Relative Temp Index, Mech w/impact (¹) 80 80 80 80 80 80 80 80 80 8	Izod Impact, notched, 23°C	600	J/m	ASTM D 256
CTE, 40°C to 40°C, flow 8.47E.05 1/°C ASTM E 831 CTE, 40°C to 40°C, xflow 9.1E.05 1/°C ASTM E 831 Relative Temp Index, Elec (¹) 60 °C U. 7468 Relative Temp Index, Mech w/impact (¹) 60 °C U. 7468 Relative Temp Index, Mech w/o impact (¹) 60 °C U. 7468 PHYSICAL Un sty J. 26 y ASTM D 792 Water Absorption, 24 hours 0.01 % ASTM D 792 Mold Shrinkage, flow, 24 hrs 0.02 % ASTM D 570 Mold Shrinkage, flow, 24 hrs 0.50 % ASTM D 955 Melt Volume Rate, MVR at 260°C/5.0 kg 0.5 % ASTM D 95 BECETRICAL ELECTRICAL Relative Permittivity, 1 GHz 2.74 EC 60250 BIAME CHARACTERISTICS (¹)	THERMAL			
CTE, 40°C to 40°C, xflow 9.1E-05 1/°C ASTM E 831 Relative Temp Index, Elec (¹) 60 °C UL 746B Relative Temp Index, Mech w/impact (¹) 60 °C UL 746B Relative Temp Index, Mech w/o impact (¹) 60 °C UL 746B PHYSICAL "C UL 746B PHYSICAL "S ASTM D 792 Water Absorption, 24 hours 0.01 % ASTM D 570 Moisture Absorption, 50% RH, 24 hrs 0.02 % ASTM D 570 Mold Shrinkage, flow, 24 hrs 0.6 − 0.65 % ASTM D 955 Mold Shrinkage, xflow, 24 hrs 0.5 − 0.56 % ASTM D 955 Melt Volume Rate, MVR at 260°C/5.0 kg 14 cm³ / 10 min ISO 1133 ELECTRICAL Z IEC 60250 Palative Permittivity, 1 GHz 2.74 2.003 EC 60250 FLAME CHARACTERISTICS (¹) EC 60250 EC 60250 FLAME CHARACTERISTICS (¹) 2.00 2.00 2.00 2.00 2.00 2.00 2.00 2.00 2.00 2.	HDT, 1.82 MPa, 3.2mm, unannealed	108	°C	ASTM D 648
Relative Temp Index, Elec (¹) 60 °C UL 7468 Relative Temp Index, Mech w/impact (¹) 60 °C UL 7468 Relative Temp Index, Mech w/o impact (¹) 60 °C UL 7468 PHYSICAL ************************************	CTE, -40°C to 40°C, flow	8.47E-05	1/°C	ASTM E 831
Relative Temp Index, Mech w/impact (1) 60 °C UL 7468 PHYSICAL Use Density 1.26 9 (20°) ASTM D 792 Water Absorption, 24 hours 0.01 % ASTM D 570 Moisture Absorption, 50% RH, 24 hrs 0.02 % ASTM D 570 Mold Shrinkage, flow, 24 hrs 0.6-0.65 % ASTM D 955 Mold Volume Rate, MVR at 260°C/5.0 kg 0.5-0.56 % ASTM D 955 BLECTRICAL Executive Permittivity, 1 GHz 2.74 EC 60250 ISSIGNED Factor, 1 GHz 0.003 EC 60250 LU Yellow Card Link E207780-101343771 UL Recognized, 94HB Flame Class Rating 0.6	CTE, -40°C to 40°C, xflow	9.1E-05	1/°C	ASTM E 831
Relative Temp Index, Mech w/o impact (¹) 60 °C U.746B PHYSICAL Density 1.26 9/cm² ASTM D 792 Water Absorption, 24 hours 0.01 % ASTM D 570 Moisture Absorption, 50% RH, 24 hrs 0.02 % ASTM D 95 Mold Shrinkage, flow, 24 hrs 0.6 – 0.65 % ASTM D 955 Melt Volume Rate, MVR at 260°C/5.0 kg 1 cm²/10 min ISO 1133 BECETRICAL ERaltive Permittivity, 1 GHz 2.74 2.74 EC 60250 ISO 1505 FLAME CHARACTERISTICS (¹) EC 60250 EC 60250 LAME CHARACTERISTICS (¹) EC 60250 EC 60250 U. Recognized, 94HB Flame Class Rating 20.7780-101343771 2 - U. Recognized, 94HB Flame Class Rating 85 – 100 °C - Dright Temperature 6 – 8 - C Dright Temperature 6 – 8 - - - - -	Relative Temp Index, Elec ⁽¹⁾	60	°C	UL 746B
PHYSICAL Pensity 1.26 0.01	Relative Temp Index, Mech w/impact (1)	60	°C	UL 746B
Density J.26 g/cm³ ASTM D 792 Water Absorption, 24 hours 0.01 % ASTM D 570 Moisture Absorption, 50% RH, 24 hrs 0.02 % ASTM D 950 Mold Shrinkage, flow, 24 hrs 0.6 – 0.65 % ASTM D 955 Mold Shrinkage, xflow, 24 hrs 0.5 – 0.56 % ASTM D 955 Melt Volume Rate, MVR at 260°C/5.0 kg 14 cm²/10 min ISO 1133 ELECTRICAL S ELEC 60250 Dissipation Factor, 1 GHz 0.003 2 IEC 60250 ELMAC CHARACTERISTICS (1) U. Yellow Card Link 207780-101343771 2 2 4 UL Recognized, 94HB Flame Class Rating 0.6 mm U. 94 4 INJECTION MOLDING % C C 5 9 1 4 1 2 1 4 1 2 1 4 4 2 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4	Relative Temp Index, Mech w/o impact (1)	60	°C	UL 746B
Water Absorption, 24 hours 0.01 % ASTM D 570 Moisture Absorption, 50% RH, 24 hrs 0.02 % ASTM D 570 Mold Shrinkage, flow, 24 hrs 0.6 – 0.65 % ASTM D 955 Mold Shrinkage, xflow, 24 hrs 0.5 – 0.56 % ASTM D 955 Melt Volume Rate, MVR at 260°C/5.0 kg 14 cm³/10 min ISO 1133 ELECTRICAL Relative Permittivity, 1 GHz 2.74 - IEC 60250 Dissipation Factor, 1 GHz 0.003 - IEC 60250 FLAME CHARACTERISTICS (1) E207780-101343771 - - UL Yellow Card Link E207780-101343771 - - UL Recognized, 94HB Flame Class Rating 0.6 mm UL 94 INIECTION MOLDING S – 100 C Drying Temperature 85 – 100 C Drying Time 6-8 hrs	PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs 0.02 % ASTM D 570 Mold Shrinkage, flow, 24 hrs 0.6-0.65 % ASTM D 955 Mold Shrinkage, xflow, 24 hrs 0.5-0.56 % ASTM D 955 Melt Volume Rate, MVR at 260°C/5.0 kg 14 cm³/10 min ISO 1133 ELECTRICAL ELECTRICAL Relative Permittivity, 1 GHz 2.74 - IEC 60250 Dissipation Factor, 1 GHz 0.003 - IEC 60250 FLAME CHARACTERISTICS (1) E207780-101343771 - - UL Yellow Card Link E207780-101343771 - - UL Recognized, 94HB Flame Class Rating 0.6 mm UL 94 INJECTION MOLDING C Drying Temperature 85 - 100 C Drying Time 6-8 hrs	Density	1.26	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs 0.6 - 0.65 % ASTM D 955 Mold Shrinkage, xflow, 24 hrs 0.5 - 0.56 % ASTM D 955 Melt Volume Rate, MVR at 260°C/5.0 kg 14 cm³/10 min ISO 1133 ELECTRICAL Feative Permittivity, 1 GHz 2.74 - IEC 60250 Dissipation Factor, 1 GHz 0.003 - - IEC 60250 ELAME CHARACTERISTICS (1) U. Yellow Card Link E207780-101343771 - - - UL Recognized, 94HB Flame Class Rating 0.6 mm UL 94 INJECTION MOLDING C Drying Temperature 85 - 100 °C Drying Time 6-8 hrs	Water Absorption, 24 hours	0.01	%	ASTM D 570
Mold Shrinkage, xflow, 24 hrs Melt Volume Rate, MVR at 260°C/5.0 kg 14 274 274 274 274 274 274 274	Moisture Absorption, 50% RH, 24 hrs	0.02	%	ASTM D 570
Melt Volume Rate, MVR at 260°C/5.0 kg ELECTRICAL Relative Permittivity, 1 GHz Dissipation Factor, 1 GHz UL Yellow Card Link LU Yellow Card Link Dissipation Flame Class Rating Dissipat	Mold Shrinkage, flow, 24 hrs	0.6 – 0.65	%	ASTM D 955
Relative Permittivity, 1 GHz Poissipation Factor, 1 GHz	Mold Shrinkage, xflow, 24 hrs	0.5 – 0.56	%	ASTM D 955
Relative Permittivity, 1 GHz Dissipation Factor, 1 GHz Dissipation Factor, 1 GHz UL Yellow Card Link UL Recognized, 94HB Flame Class Rating Disping Temperature Drying Temperature Drying Time 2.74 D.274 D	Melt Volume Rate, MVR at 260°C/5.0 kg	14	cm³/10 min	ISO 1133
Dissipation Factor, 1 GHz 0.003 - IEC 60250 FLAME CHARACTERISTICS (1) E207780-101343771 - - UL Yellow Card Link E207780-101343771 - - - UL Recognized, 94HB Flame Class Rating 0.6 mm UL 94 INJECTION MOLDING TO C Drying Temperature 85 – 100 hrs	ELECTRICAL			
FLAME CHARACTERISTICS (1) E207780-101343771 - - UL Recognized, 94HB Flame Class Rating 0.6 mm UL 94 INJECTION MOLDING Drying Temperature 85 – 100 °C Drying Time 6 – 8 hrs	Relative Permittivity, 1 GHz	2.74	-	IEC 60250
UL Yellow Card Link E207780-101343771 -	Dissipation Factor, 1 GHz	0.003	-	IEC 60250
UL Recognized, 94HB Flame Class Rating 0.6 mm UL 94 INJECTION MOLDING °C Drying Temperature 6 – 8 hrs	FLAME CHARACTERISTICS (1)			
INJECTION MOLDING Drying Temperature 85 – 100 °C Drying Time 6 – 8 hrs	UL Yellow Card Link	E207780-101343771	-	-
Drying Temperature 85 – 100 °C Drying Time 6 – 8 hrs	UL Recognized, 94HB Flame Class Rating	0.6	mm	UL 94
Drying Temperature 85 – 100 °C Drying Time 6 – 8 hrs	INJECTION MOLDING			
, 5	Drying Temperature	85 – 100	°C	
	Drying Time	6 – 8	hrs	
	Melt Temperature	250 – 290	°C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Nozzle Temperature	250 – 290	°C	
Front - Zone 3 Temperature	250 – 280	°C	
Middle - Zone 2 Temperature	250 – 270	°C	
Rear - Zone 1 Temperature	250 – 270	°C	
Mold Temperature	60 – 90	°C	
Back Pressure	0.3 - 0.7	MPa	
Screw Speed	40 – 70	rpm	

⁽¹⁾ UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

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