

LNP* Thermocomp* Compound HX03409C

Americas: COMMERCIAL

LNP* THERMOCOMP* HX03409C is a compound based on PA11 resin containing Metal Filler. Added features include: Clean Compound System, High Specific Gravity.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield, 50 mm/min	33	MPa	ISO 527
Tensile Strain, break, 50 mm/min	42	%	ISO 527
Tensile Modulus, 1 mm/min	1500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	51	MPa	ISO 178
Flexural Modulus, 2 mm/min	1900	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched 80*10*4 +23°C	75	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
CTE, 23°C to 60°C, flow	1.36E-04	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.1E-04	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	146	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	50	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Mold Shrinkage, flow (5)	1.8	%	SABIC Method
Density	2.24	g/cm ³	ISO 1183
Water Absorption, 23°C/24hrs	0.1	%	ISO 62-1

Source GMD, last updated:2010/06/02

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15	%
Melt Temperature	225 - 260	°C
Front - Zone 3 Temperature	260 - 270	°C
Middle - Zone 2 Temperature	230 - 245	°C
Rear - Zone 1 Temperature	200 - 210	°C
Mold Temperature	45 - 55	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

Source GMD, last updated:2010/06/02

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.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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