

LNP* Thermocomp* Compound EX00781H Americas: DEVELOPMENTAL

Also known as: EX06316C
Product Reorder Name: EX00781H

A self lubricating Compound based on Ultem resin featuring low levels of leachable fluoride ions, suitable for use in abrasive wear conditions and wear against soft metals

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	91	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	90	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	5.9	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	5.3	%	ASTM D 638
Tensile Modulus, 5 mm/min	3320	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	145	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3150	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	91	MPa	ISO 527
Tensile Stress, break, 5 mm/min	89	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5.4	%	ISO 527
Tensile Strain, break, 5 mm/min	6	%	ISO 527
Tensile Modulus, 1 mm/min	3250	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	148	MPa	ISO 178
Flexural Modulus, 2 mm/min	3310	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	37	J/m	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	4	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	189	°C	ASTM D 648
Vicat Softening Temp, Rate B/120	213	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	189	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.31	-	ASTM D 792
Melt Flow Rate, 337°C/6.6 kgf	12.3	g/10 min	ASTM D 1238
Density	1.31	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 340°C/5.0 kg	10	cm ³ /10 min	ISO 1133

Source GMD, last updated:06/05/2007

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	150	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	350 - 400	°C

Nozzle Temperature	345 - 400	°C
Front - Zone 3 Temperature	345 - 400	°C
Middle - Zone 2 Temperature	340 - 400	°C
Rear - Zone 1 Temperature	330 - 400	°C
Mold Temperature	135 - 165	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

Source GMD, last updated:06/05/2007

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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