

LNP\* Stat-kon\* Compound Noryl\_HMC1010

Americas: COMMERCIAL

LNP\* Stat-kon\* Noryl\_HMC1010 compound is a 10% Carbon fiber reinforced. Static dissipative. Nonbrominated, nonchlorinated flame retardant system. UL94 V-1 rated.

Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	79	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	71	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	103	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	6890	MPa	ASTM D 790
Hardness, Rockwell R	122	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	83	mg/1000cy	ASTM D 1044
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	240	J/m	ASTM D 4812
Izod Impact, notched, 23°C	69	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 6.4 mm, unannealed	111	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	105	°C	ASTM D 648
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.15	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.05 - 0.15	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.15 - 0.3	%	SABIC Method
ELECTRICAL	Value	Unit	Standard
Volume Resistivity	8.E+03	Ohm-cm	ASTM D 257
Surface Resistivity	1.3E+04	Ohm	ASTM D 257
Static Decay, 5000V to <50V	0.01	< seconds	FTMS101B
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94V-1 Flame Class Rating (3)	2	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2	mm	UL 94

Source GMD, last updated:03/15/1999

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	90 - 95	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	255 - 280	°C
Nozzle Temperature	255 - 280	°C

Front - Zone 3 Temperature	245 - 280	°C
Middle - Zone 2 Temperature	230 - 275	°C
Rear - Zone 1 Temperature	220 - 270	°C
Mold Temperature	65 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.038 - 0.051	mm

Source GMD, last updated:03/15/1999

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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