

LNP* Konduit* Compound PX08322

Asia Pacific: COMMERCIAL

Also known as: PX08322

Product Reorder Name: PX08322

Thermally conductive mineral filled PA6 FR compound, with through-plane and in-plane thermal conductivity of 2.1 W/(m*K) and 8.1 W/(m*K) respectively, conforming to ASTM E 1461 test standard.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, brk, Type I, 5 mm/min	54	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	0.6	%	ASTM D 638
Tensile Modulus, 50 mm/min	11790	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	82	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	11700	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	88	J/m	ASTM D 4812
Izod Impact, notched, 23°C	17	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	180	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.15E+01	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	3.54E+01	1/°C	ASTM E 831
Thermal Conductivity	2.3	W/m-°C	ASTM E 1530
PHYSICAL	Value	Unit	Standard
Density	1.53	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.45	%	ASTM D 955
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94V-0 Flame Class Rating (3)	1.2	mm	UL 94
Glow Wire Ignitability Temperature, 1.0 mm	825	°C	IEC 60695-2-13

Source GMD, last updated:2009/04/24

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	3 - 4	hrs
Melt Temperature	250 - 280	°C
Nozzle Temperature	250 - 280	°C
Front - Zone 3 Temperature	250 - 280	°C
Middle - Zone 2 Temperature	240 - 280	°C
Rear - Zone 1 Temperature	230 - 270	°C
Mold Temperature	80 - 100	°C
Back Pressure	3 - 9	MPa
Screw Speed	30 - 150	rpm

Source GMD, last updated:2009/04/24

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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