

*Non-blomine/non-phosphor type
Flame Resistant Grade (High Impact type)*

Panlite®

LN-2520A series

Technical Date

***TEIJIN CHEMICAL Ltd.,
Plastics Technical Center***

1. Data sheet

Properties	Unit	Test method	Measurement condition	Non-blomine/non-phosphor type (High Impact type)	
				LN-2520A	LN-2520HA
Density	Kg/m ³	ISO1183	-	1,200	1,200
Tensile yield stress	MPa	ISO527-1 and ISO527-2	-	64	64
Tensile yield distortion	%		-	7	7
Tensile fracture stress	MPa	ISO527-1 and ISO527-2	-	65	65
Tensile fracture distortion	%		-	120	120
Flexural strength	MPa	ISO178	-	98	94
Flexural modulus			-	2,280	2,280
Charpy impact strength	KJ/m ²	ISO179	notched	13	19
			unnotched	NB	NB
Load-deflection temperature		ISO75-1 and ISO75-2	1.80MPa	127	127
Mold shrinkage (Thickness : 4mm)	%	In – house method	parallel	0.5 - 0.7	0.5 - 0.7
			vertical	0.5 - 0.7	0.5 - 0.7
Coefficient of linear expansion	×10 ⁻⁴ /	ISO11359-2	parallel	0.7	0.7
			vertical	0.7	0.7
Flammability	-	UL94	1.0 mm	V-0	V-0
			2.0 mm	5VB	5VB
			3.0 mm	V-0	V-0

* The values listed are specification values, not certified values.



2. Flowability

Test Condition

Injection apparatus : Sumitomo Heavy Industries SG-150U

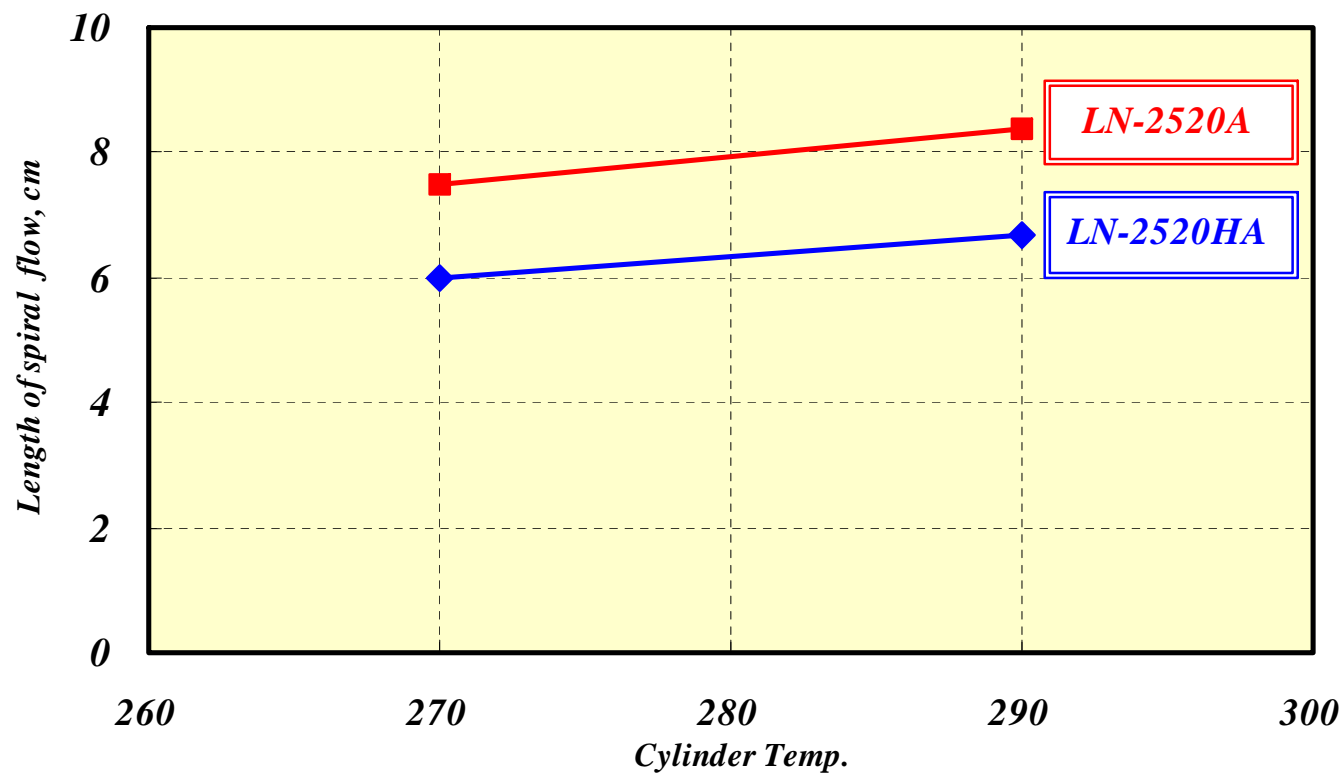
Cylinder Temp. : 270 - 290

Die Temp. : 70

Type of Die : Archimedean spiral flow

Thickness of flow path : 1 mmt

Injection pressure : 98 MPa



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3. High-speed punncture properties

Test Condition

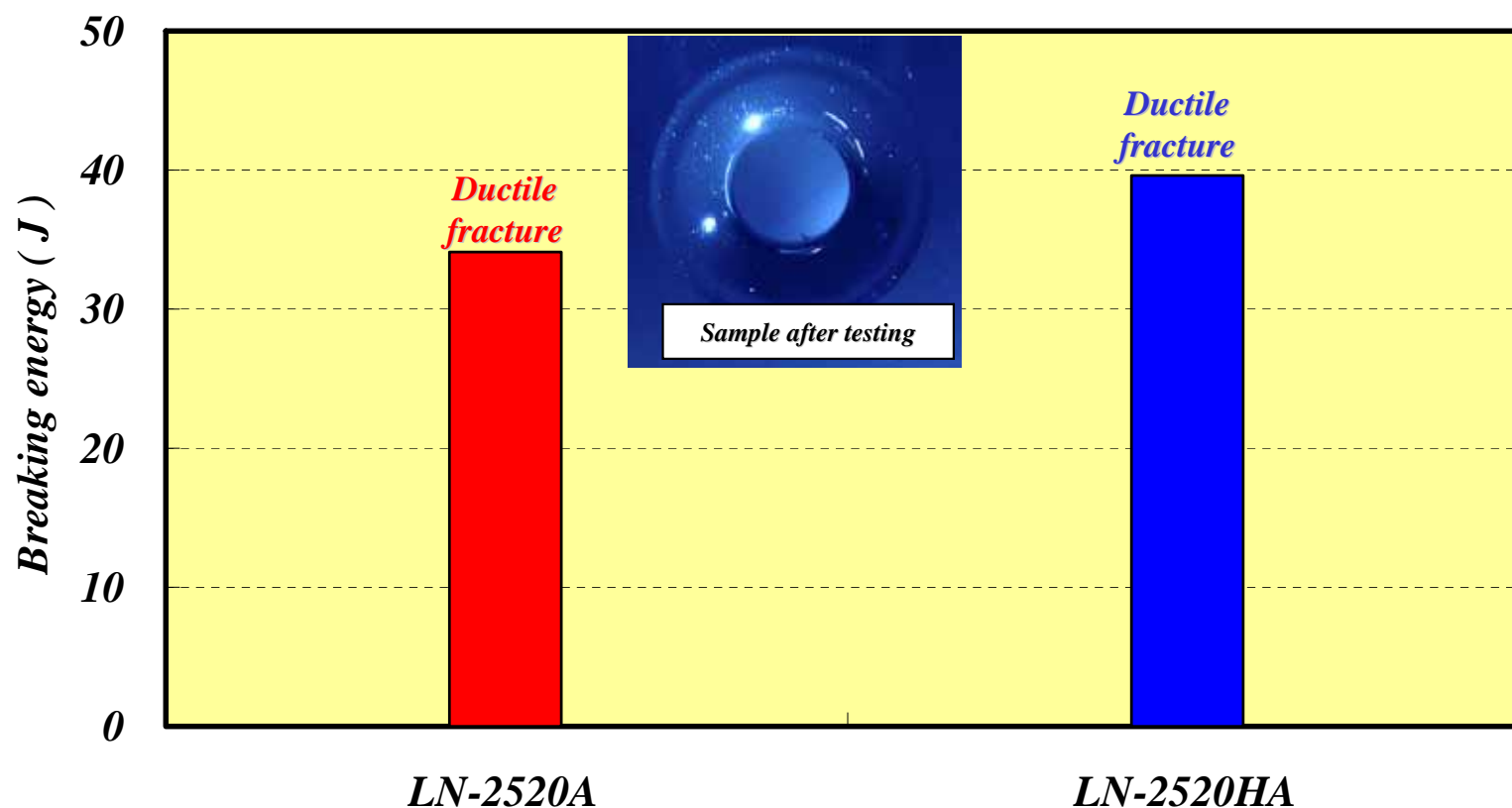
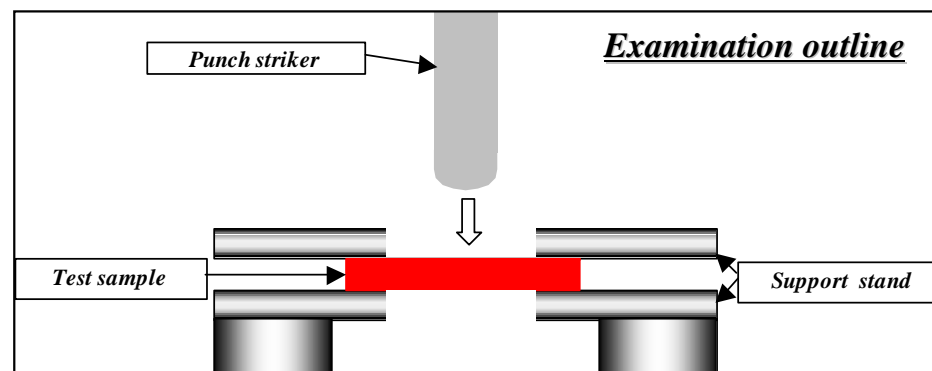
Testing machine : Shimadzu Coporation Hydro-shot MTH-1

Test sample : 2mm thick plate

Radial of the support stand : 1/2 inches (12.8mm)

Radial of the punch striker : 6.4 mm

Load speed : 5.4 m/s (setting)



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4. Molding condition

(1) Predrying

The water content of Planlite® LN-2520A series is about 0.2 % at room temperature. In order to obtain good molding results, reduce the product moisture content to 0.02 % or below. This will also avoid problems with deterioration in physical properties, foaming and silver streaking caused by hydrolysis. When pre-drying Planlite® LN-2520A series using a box-type dryer, thickness of the pellet layer should be 3 cm or less. and the dryer should be run for 5 to 8 hours, maintaining the temperature of 120 °C. The hopper of the molding machine should be heated to maintain the pellet temperature between 100 °C and 120 °C, and to avoid moisture absorption.

(2) Injection Molding

Standard injection molding condition of Planlite are shown in the following tables.

Select a molding machine with a shot capacity of 1.5 – 3 times as that of the weight of the molded product.

<Molding condition for Planlite® LN-2520A series >

Condition	Unit	LN-2520A series
Predrying		120
Drying time	hours	5 - 8
Molding Temp.		270 - 320
Die Temp.		80 - 120
Injection pressure	MPa	98 - 147

CAUTION

- (1) The figures listed in this Technical data are typical values obtained under standard test methods, and may not be applicable for products that are used under different application condition.
- (2) The combustion figures listed in this Technical data are from small-scale test and may not be applicable for hazards during a major fire.
- (3) Please refer to us for an advice regarding the application conditions for medical equipment, food service application, and toys.
- (4) When any kind of additives (such as anti-bacterial agents, stabilizers and flame retardants) or coloring agents are to be added to this resin, please be sure to consult with Teijin Chemical Ltd., in advance. However, even after consultation, Teijin Chemical Ltd., will not guarantee not bear responsibility in any form for usage of such additives.
- (5) Please carefully consider all potential industrial property rights when considering applications introduced in the Technical data.
- (6) The contents of this Technical data may be changed without prior notice.
- (7) Please refer to the Material Safety Data Sheet (MSDS) before use for other warnings in detail.