

Data sheet

Properties	Unit	Test method	Measurement condition	LN-2520V
Density	kg/m ³	ISO1183	—	1,200
Tensile yield stress	MPa	ISO527-1 & -2	—	64
Tensile fracture stress	MPa	ISO527-1 & -2	—	65
Tensile fracture distortion	%		—	120
Flexural strength	MPa	ISO178	—	94
Flexural modulus			—	2,280
Charpy impact strength	KJ/m ²	ISO179	notched	19
			unnotched	NB
Load-deflection temperature	°C	ISO75-1 & -2	1.80MPa	127
Mold shrinkage (Thickness : 4mm)	%	in-house method	parallel	0.5 - 0.7
			vertical	0.5 - 0.7
Coefficient of linear expansion	×10 ⁻⁴ /°C	ISO11359-2	parallel	0.7
			vertical	0.7
Flammability	—	UL94	1.0 mm	V-0
			1.5mm	V-0
			3.0 mm	V-0, 5VA
Temperature index	°C	UL 746B	electric:1.5mm	130
			impact:1.5mm	125
			non-impact:1.5mm	130

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



(1) Predrying

The water content of Panlite® LN-2520V 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 Panlite® LN-2520V 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 Panlite 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 Panlite® LN-2520V >

Condition	Unit	LN-2520V
Predrying	°C	120
Drying time	hours	5 - 8
Molding Temp.	°C	270 - 320
Die Temp.	°C	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.

