



SUMIKASUPER E6810LHF Z

		Method	Unit	E6810LHF Z
Color				Natural, Black
Filler		-		Glass fiber/Mineral
Glass fiber type		-		Chopped
Filler content		-	%	50
Physical property				
Specific gravity		ASTM D792		1.82
Mold shrinkage	MD	Sumitomo Original*1	%	0.13
	TD		%	0.38
Mechanical property				
Tensile	strength	ASTM D638	MPa	105
	elongation		%	4.0
	strength	ISO 527	MPa	95
	modulus		GPa	-
	elongation		%	1.1
Flexural	strength	ASTM D790	MPa	133
	modules		GPa	12.6
	strength	ISO 178	MPa	150
	modulus		GPa	13.7
Izod impact strength		D256	J/m	200
Non-notched		ISO 180	J/m	154
Charpy impact strength		ISO 179	KJ/m ²	-
Non-notched			KJ/m ²	25
Rockwell strength			R scale	102
Thermal property				
TDUL		ASTM D648	deg C	266
1.82MPa for ASTM/1.80MPa for ISO		ISO 75	deg C	273
Solder resistance		Sumitomo Original*2	deg C	280
Liner expansion coefficient	MD	Sumitomo Original*3	×10 ⁻⁵ /deg C	0.5
	TD			
Electrical property				
Dielectric constant	ASTM D150		1MHz	4.1
			1GHz	3.8
Dielectric tangent			1MHz	0.020
			1GHz	0.004
Dielectric breakdown voltage		Short time method	kV/mm	-
Specific volume resistance		ASTM D257	Ωm	10 ¹³
Specific surface resistance			Ω	-

Arc resistance	ASTM D495	sec.	181
Tracking resistance	IEC method	V	200
Flammability			
Flame retardency	UL 94		V-0 at 0.3mmt
Limited Oxygen Index	JIS K 7201		48

<Note>

All the data above are just for reference, not intended for any guarantee on the product.

*1: The tool of 64mm X 64mm X 3mmt was used to determine mold shrinkages.

*2: The highest temperature at which dumbbell shaped test pieces of 1.2mmt does not deform after immersing in a solder bath for 60 seconds.

*3: The center part of the test piece for tensile property was used.

Standard molding conditions			
Pre-drying		deg C for hours	About 130 deg C for 4 to 24 hours
Cylinder temperature	Nozzle	deg C	340 to 360
	Front	deg C	340 to 360
	Middle	deg C	320 to 340
	Rear	deg C	280 to 320
Suitable resin temperature		deg C	350
Tool (Mold) temperature		deg C	40 to 160
Injection velocity		-	Middle to High
Injection pressure		MPa	80 to 160
Holding pressure		MPa	20 to 40
Back pressure		MPa	1 to 5
Screw rotation		rpm	50 to 100