LNP™ COLORCOMP™ COMPOUND M1000S

M-1000 HS

DESCRIPTION

LNP COLORCOMP* M1000S is an unfilled Polypropylene resin. Added features of this material include: Heat Stabilized.

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	28	MPa	ISO 527
Tensile Stress, break	26	MPa	ISO 527
Tensile Strain, yield	7	%	ISO 527
Tensile Strain, break	40	%	ISO 527
Tensile Modulus, 1 mm/min	2160	MPa	ISO 527
Flexural Stress	40	MPa	ISO 178
Flexural Modulus	1800	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	3	kJ/m²	ISO 180/1A
THERMAL			
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	130	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	94	°C	ISO 75/Af
PHYSICAL			
Density	1.13	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	1.5 – 1.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1.5 – 1.7	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	1.51 – 1.67	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	1.51 – 1.67	%	ISO 294
Density	1.12	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Melt Temperature	215 – 220	°C	
Front - Zone 3 Temperature	205 – 215	°C	
Middle - Zone 2 Temperature	200 – 210	°C	
Rear - Zone 1 Temperature	195 – 205	°C	
Mold Temperature	30 – 50	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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