LNP™ THERMOCOMP™ COMPOUND KF002L

KF-1002 LE
REGION ASIA

DESCRIPTION

LNP THERMOCOMP KF002L is a compound based on Acetal CoPolymer resin containing 10% Glass Fiber. Added features of this material include: Low Extractible.

TYPICAL PROPERTY VALUES

Revision 20190807

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	66	MPa	ASTM D 638
Tensile Stress, break	63	MPa	ASTM D 638
Tensile Strain, yield	2.2	%	ASTM D 638
Tensile Strain, break	3.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	6200	MPa	ASTM D 638
Flexural Stress	103	MPa	ASTM D 790
Flexural Modulus	4820	MPa	ASTM D 790
Tensile Stress, yield	65	MPa	ISO 527
Tensile Stress, break	63	MPa	ISO 527
Tensile Strain, yield	2.1	%	ISO 527
Tensile Strain, break	3.2	%	ISO 527
Tensile Modulus, 1 mm/min	5600	MPa	ISO 527
Flexural Stress	105	MPa	ISO 178
Flexural Modulus	4400	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	384	J/m	ASTM D 4812
Izod Impact, notched, 23°C	42	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	6	J	ASTM D 3763
Multiaxial Impact	2	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	26	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	162	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	155	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.08E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.4E-06	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	1.12E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.05E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	162	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	148	°C	ISO 75/Af
PHYSICAL			
Density	1.49	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, flow, 24 hrs	1.6 – 1.8	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1.5 – 1.7	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	1.7	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	1.6	%	ISO 294
Density	1.49	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Melt Temperature	200 – 215	°C	
Front - Zone 3 Temperature	210 – 220	°C	
Middle - Zone 2 Temperature	195 – 205	°C	
Rear - Zone 1 Temperature	175 – 190	°C	
Mold Temperature	80 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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