LNP™ THERMOCOMP™ COMPOUND KF004

KF-1004
REGION EUROPE

DESCRIPTION

LNP THERMOCOMP* KF004 is a compound based on Acetal Copolymer resin containing 20% Glass Fiber.

TYPICAL PROPERTY VALUES

Revision 20190812

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	104	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.3	%	ISO 527
Tensile Modulus, 1 mm/min	7200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	122	MPa	ISO 178
Flexural Modulus, 2 mm/min	5500	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	6.3E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.07E-04	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	157	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	0.5	%	SABIC method
Density	1.54	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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