LNP™ THERMOCOMP™ COMPOUND KF004A

KF-1004 D

DESCRIPTION

LNP THERMOCOMP* KF004A is a compound based on Acetal Homopolymer resin containing 20% Glass Fiber.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	99	MPa	ASTM D 638
Tensile Strain, break	2.2	%	ASTM D 638
Flexural Stress	144	MPa	ASTM D 790
Flexural Modulus	7100	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	427	J/m	ASTM D 4812
Izod Impact, notched, 23°C	58	J/m	ASTM D 256
PHYSICAL			
Density	1.56	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.6	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	2	%	ASTM D 955
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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