LNP™ THERMOCOMP™ COMPOUND MFB22S

MFX-1004 HS MG

DESCRIPTION

LNP THERMOCOMP MFB22S is a compound based on Polypropylene containing 10% Glass Fiber, 10% Glass Bead. Added feature of this grade is: Heat Stabilized.

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	47	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	45	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3.2	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4.1	%	ASTM D 638
Tensile Modulus, 5 mm/min	3660	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	73	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2830	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.2	%	ISO 527
Tensile Strain, break, 5 mm/min	3.6	%	ISO 527
Tensile Modulus, 1 mm/min	3250	MPa	ISO 527
Flexural Stress	70	MPa	ISO 178
Flexural Modulus, 2 mm/min	2770	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	406	J/m	ASTM D 4812
Izod Impact, notched, 23°C	52	J/m	ASTM D 256
Multiaxial Impact	2	J	ISO 6603
Instrumented Impact Total Energy, 23°C	7	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	25	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	156	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	135	°C	ASTM D 648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	148	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	103	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.04	-	ASTM D 792
Density	1.035	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.03	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	1 – 3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.04	%	ISO 62
INJECTION MOLDING			
Drying Temperature	80	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	4	hrs	
Melt Temperature	225 – 250	°C	
Front - Zone 3 Temperature	240 – 250	°C	
Middle - Zone 2 Temperature	215 – 225	°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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