LNP™ THERMOCOMP™ COMPOUND MFB63

DESCRIPTION

LNP THERMOCOMP MFB63 is a compound based on Polypropylene resin containing Glass Bead, Glass Fiber.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	64	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3.3	%	ISO 527
Tensile Modulus, 1 mm/min	5400	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	4900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	40	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	3.5E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.12E-04	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	154	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	133	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	0.4 – 0.5	%	SABIC method
Density	1.22	g/cm³	ISO 1183
Water Absorption, 23°C/24hrs	0.02	%	ISO 62-1
INJECTION MOLDING			
Drying Temperature	80	°C	
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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