LNP™ THERMOCOMP™ COMPOUND MX06402H

MF-1004 HS LE

DESCRIPTION

LNP THERMOCOMP MX06402H is a compound based on Polypropylene resin containing 20% Glass Fiber. Added features of this material include: Heat Stabilized, Low Extractable.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	38	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	34	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	6390	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	66	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	4700	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	37	MPa	ISO 527
Tensile Stress, break, 5 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	1.7	%	ISO 527
Tensile Strain, break, 5 mm/min	2.7	%	ISO 527
Tensile Modulus, 1 mm/min	5350	MPa	ISO 527
Flexural Stress	65	MPa	ISO 178
Flexural Modulus, 2 mm/min	4690	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	195	J/m	ASTM D 4812
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
Multiaxial Impact	2	J	ISO 6603
Instrumented Impact Total Energy, 23°C	12	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	13	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	143	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	103	°C	ASTM D 648
CTE, -30°C to 30°C, flow	4.5E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	1.01E-04	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	134	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	95	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.06	-	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.7 – 0.9	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
Density	1.05	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.01	%	ISO 62

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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