LNP™ THERMOCOMP™ COMPOUND MX06403

MF-1004 HS UV HP

DESCRIPTION

LNP THERMOCOMP MX06403 is a compound based on Polypropylene resin containing 20% Glass Fiber. Added features of this material include: Heat Stabilized, UV Stabilized.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	50	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3 – 4	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	66	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3100	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	293	J/m	ASTM D 4812
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	140	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.04	-	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.5 – 0.6	%	ASTM D 955
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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