LNP™ THERMOCOMP™ COMPOUND MX95319

PDX-M-95319

DESCRIPTION

LNP THERMOCOMP MX95319 is a compound based on Polypropylene resin containing Proprietary Filler(s).

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	66	MPa	ASTM D 638
Tensile Strain, break	3.1	%	ASTM D 638
Flexural Stress	103	MPa	ASTM D 790
Flexural Modulus	4130	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	534	J/m	ASTM D 4812
Izod Impact, notched, 23°C	42	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	145	°C	ASTM D 648
PHYSICAL			
Density	1.04	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1	%	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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