LNP™ THERMOCOMP™ COMPOUND WFZ629

WF-1008 FR-S MG

DESCRIPTION

LNP™ THERMOCOMP™ WFZ629 is a compound based on PBT resin containing 40% Mixed Glass. Added features of this material include: Flame Retardant.

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	72.3	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.62	%	ASTM D 638
Tensile Modulus, 50 mm/min	10980	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	131	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	9460	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	71	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.56	%	ISO 527
Tensile Modulus, 1 mm/min	10452	MPa	ISO 527
Flexural Stress, break, 2 mm/min	124	MPa	ISO 178
Flexural Modulus, 2 mm/min	9529	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	4.5	kJ/m²	ISO 180/1A
Izod Impact, notched, 23°C	38.2	J/m	ASTM D 256
Izod Impact, unnotched, 23°C	301	J/m	ASTM D 4812
Izod Impact, unnotched 80*10*4 +23°C	18.9	kJ/m²	ISO 180/1U
Multiaxial Impact	7	J	ASTM D 3763
Multiaxial Impact	2.2	J	ISO 6603
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	179	°C	ASTM D 648
HDT, 0.45 MPa, 3.2 mm, unannealed	209	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	164	°C	ISO 75/Af
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	203	°C	ISO 75/Bf
CTE, -30°C to 30°C, xflow	55.8	1/°C	ASTM D 696
CTE, -30°C to 30°C, flow	29.4	1/°C	ASTM D 696
PHYSICAL			
Density	1.83	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.2 – 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1.0 – 3.0	%	ASTM D 955
Moisture Absorption, 50% RH, 24 hrs	0.05	%	ASTM D 570
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Density	1.83	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	121	°C	
Drying Time	4	hrs	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Temperature	243 – 260	°C	
Mold Temperature	82 – 99	°C	
Screw Speed	30 – 60	rpm	
Back Pressure	0.17 – 0.34	MPa	
Rear - Zone 1 Temperature	232 – 260	°C	

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