LNP™ THERMOCOMP™ COMPOUND WZ002

WF-1002 M

DESCRIPTION

LNP THERMOCOMP WZ002 is a compound based on PBT resin containing 10% Milled Glass.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	47	MPa	ISO 527
Tensile Stress, break, 5 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.3	%	ISO 527
Tensile Strain, break, 5 mm/min	2.4	%	ISO 527
Tensile Modulus, 1 mm/min	5000	MPa	ISO 527
Flexural Stress, break, 2 mm/min	85	MPa	ISO 178
Flexural Modulus, 2 mm/min	2900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	20	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	3	kJ/m²	ISO 180/1A
THERMAL			
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	149	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	64	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	1.9	%	SABIC method
Density	1.4	g/cm³	ISO 1183
Water Absorption, 23°C/24hrs	0.1	%	ISO 62-1
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.05	%	
Melt Temperature	240 – 265	°C	
Front - Zone 3 Temperature	260 – 270	°C	
Middle - Zone 2 Temperature	245 – 255	°C	
Rear - Zone 1 Temperature	220 – 230	°C	
Mold Temperature	80 – 100	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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