LNP™ THERMOCOMP™ COMPOUND ZFM3314M

ZFM-3314M

DESCRIPTION

glas, mineral filled PPE

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	95	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.1	%	ISO 527
Tensile Modulus, 1 mm/min	6100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	145	MPa	ISO 178
Flexural Modulus, 2 mm/min	5800	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	3.2E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	6.2E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/120	179	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	170	°C	ISO 75/Af
PHYSICAL			
Density	1.25	g/cm³	ISO 1183
Melt Volume Rate, MVR at 300°C/5.0 kg	17	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	2 – 8	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	295 – 315	°C	
Nozzle Temperature	295 – 315	°C	
Front - Zone 3 Temperature	280 – 315	°C	
Middle - Zone 2 Temperature	270 – 310	°C	
Rear - Zone 1 Temperature	260 – 305	°C	
Mold Temperature	75 – 105	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 70	%	

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