LNP™ THERMOCOMP™ COMPOUND KFB11

KFX-1002 MG
REGION ASIA

DESCRIPTION

LNP THERMOCOMP KFB11 is a compound based on Acetal Copolymer resin containing 5% Glass Fiber, 5% Glass Bead. Added features of this material include: Low Warpage, Chemically Coupled.

TYPICAL PROPERTY VALUES

Revision 20181219

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	64	MPa	ASTM D 638
Tensile Stress, break	62	MPa	ASTM D 638
Tensile Strain, yield	4	%	ASTM D 638
Tensile Strain, break	5.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	4130	MPa	ASTM D 638
Flexural Modulus	3440	MPa	ASTM D 790
Tensile Stress, yield	65	MPa	ISO 527
Tensile Stress, break	60	MPa	ISO 527
Tensile Strain, yield	3.9	%	ISO 527
Tensile Strain, break	7	%	ISO 527
Tensile Modulus, 1 mm/min	4100	MPa	ISO 527
Flexural Stress	91	MPa	ISO 178
Flexural Modulus	3000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	528	J/m	ASTM D 4812
Izod Impact, notched, 23°C	53	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	6	J	ASTM D 3763
Multiaxial Impact	1	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	35	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	162	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	152	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.08E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.64E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	1.07E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.6E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	161	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	150	°C	ISO 75/Af
PHYSICAL			
Density	1.48	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	1 – 3	%	ASTM D 955

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	1.9	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	1.7	%	ISO 294
Density	1.48	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Melt Temperature	200 – 215	°C	
Front - Zone 3 Temperature	210 – 220	°C	
Middle - Zone 2 Temperature	195 – 205	°C	
Rear - Zone 1 Temperature	175 – 190	°C	
Mold Temperature	80 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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