LNP™ THERMOTUF™ Compound MX00619

PDX-M-00619

DESCRIPTION

LNP THERMOTUF MX00619 compound is based on Polypropylene (PP) resin containing 15% glass fiber. Added features of this grade include: High Impact.

GENERAL INFORMATION	
Features	Impact resistant, No PFAS intentionally added
Fillers	Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
Polymer Types	Polypropylene, Unspecified (PP, Unspecified)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Consumer	Sport/Leisure, Personal Accessory
Electrical and Electronics	Mobile Phone - Computer - Tablets
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, break	37	MPa	ASTM D638
Tensile Strain, break	2.6	%	ASTM D638
Tensile Modulus, 50 mm/min	3140	MPa	ASTM D638
Flexural Stress	55	MPa	ASTM D790
Flexural Modulus	2810	MPa	ASTM D790
IMPACT [1]			
Izod Impact, unnotched, 23°C	336	J/m	ASTM D4812
Izod Impact, notched, 23°C	90	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	137	°C	ASTM D648
PHYSICAL [1]			
Density	0.99	g/cm³	ASTM D792
Mold Shrinkage, flow, 24 hrs [2]	0.2	%	ASTM D955
INJECTION MOLDING [3]			
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	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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