LNP™ COLORCOMP™ COMPOUND M1000S

M-1000 HS

DESCRIPTION

LNP COLORCOMP M1000S compound is based on Polypropylene (PP) resin. Added features of this grade include: Heat Stabilised.

GENERAL INFORMATION	
Features	Heat Stabilized, Aesthetics/Visual effects, No PFAS intentionally added
Fillers	Unreinforced
Polymer Types	Polypropylene, Unspecified (PP, Unspecified)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Automotive	Automotive Interiors
Consumer	Home Decoration, Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance

TYPICAL PROPERTY VALUES

Revision 20241028

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yield	28	MPa	ISO 527
Tensile Stress, break	26	MPa	ISO 527
Tensile Strain, yield	7	%	ISO 527
Tensile Strain, break	40	%	ISO 527
Tensile Modulus, 1 mm/min	2160	MPa	ISO 527
Flexural Stress	30	MPa	ISO 178
Flexural Modulus	1600	MPa	ISO 178
IMPACT [1]			
Izod Impact, notched 80*10*4 +23°C	3	kJ/m²	ISO 180/1A
THERMAL [1]			
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	130	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	94	°C	ISO 75/Af
PHYSICAL [1]			
Melt Flow Rate, 230°C/2.16 kgf	6	g/10 min	ASTM D1238
Density	1.13	g/cm³	ASTM D792
Mold Shrinkage, flow, 24 hrs [2]	1.5 – 1.7	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs [2]	1.5 – 1.7	%	ASTM D955
Mold Shrinkage, flow, 24 hrs [2]	1.51 – 1.67	%	ISO 294
Mold Shrinkage, xflow, 24 hrs [2]	1.51 – 1.67	%	ISO 294
Density	1.12	g/cm³	ISO 1183
INJECTION MOLDING [3]			
Drying Temperature	80	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	4	Hrs	
Melt Temperature	215 – 220	°C	
Front - Zone 3 Temperature	205 – 215	°C	
Middle - Zone 2 Temperature	200 – 210	°C	
Rear - Zone 1 Temperature	195 – 205	°C	
Mold Temperature	30 – 50	°C	
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.

DISCLAIMER