LNP™ THERMOCOMP™ Compound KF004

KF-1004
REGION EUROPE

DESCRIPTION

LNP THERMOCOMP KF004 compound is based on POM (Acetal) copolymer resin containing 20% glass fiber.

GENERAL INFORMATION	
Features	High stiffness/Strength, No PFAS intentionally added
Fillers	Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
Polymer Types	Acetal (POM) Copolymer
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component
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, 5 mm/min	104	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.3	%	ISO 527
Tensile Modulus, 1 mm/min	7200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	122	MPa	ISO 178
Flexural Modulus, 2 mm/min	5500	MPa	ISO 178
IMPACT [1]			
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
THERMAL [1]			
CTE, 23°C to 60°C, flow	6.3E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.07E-04	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	157	°C	ISO 75/Af
PHYSICAL [1]			
Mold Shrinkage, flow [2]	0.5	%	SABIC method
Density	1.54	g/cm³	ISO 1183
INJECTION MOLDING [3]			
Drying Temperature	80	°C	
Drying Time	4	Hrs	
Melt Temperature	200 – 215	°C	
Front - Zone 3 Temperature	210 – 220	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	

(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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