LNP™ THERMOCOMP™ Compound KFZ24XXP

KFX-1006 MG

DESCRIPTION

LNP THERMOCOMP KFZ24XXP compound is based on POM (Acetal) copolymer resin containing 20% glass fiber, 10% milled glass. Added features of this grade include: Low Warpage.

GENERAL INFORMATION	
Features	Low Warpage, Dimensional stability, High stiffness/Strength, No PFAS intentionally added
Fillers	Milled Glass Fiber, Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
Polymer Types	Acetal (POM) Copolymer
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	105	MPa	ASTM D638
Tensile Strain, break	2.5	%	ASTM D638
Tensile Modulus, 50 mm/min	8540	MPa	ASTM D638
Flexural Stress	165	MPa	ASTM D790
Flexural Modulus	7580	MPa	ASTM D790
Tensile Stress, break	109	MPa	ISO 527
Tensile Strain, break	2.6	%	ISO 527
Tensile Modulus, 1 mm/min	8900	MPa	ISO 527
Flexural Stress	171	MPa	ISO 178
Flexural Modulus	9400	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched, 23°C	534	J/m	ASTM D4812
Izod Impact, notched, 23°C	64	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	10	J	ASTM D3763
Multiaxial Impact	2	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	36	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	163	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	161	°C	ASTM D648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	160	°C	ISO 75/Af

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
PHYSICAL [1]			
Density	1.64	g/cm³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.1	%	ASTM D570
Mold Shrinkage, flow, 24 hrs [2]	0.7	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs [2]	1.3	%	ASTM D955
Mold Shrinkage, flow, 24 hrs [2]	0.66	%	ISO 294
Mold Shrinkage, xflow, 24 hrs [2]	1.3	%	ISO 294
Density	1.64	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	
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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