LNP™ THERMOCOMP™ Compound MX06403

MF-1004 HS UV HP

DESCRIPTION

LNP THERMOCOMP MX06403 compound is based on Polypropylene (PP) resin containing 20% glass fiber. Added features of this grade include: Heat Stabilized, UV Stabilized.

GENERAL INFORMATION	
Features	Heat Stabilized, High stiffness/Strength, Weatherable/UV stable, 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
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, brk, Type I, 5 mm/min	50	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	3 – 4	%	ASTM D638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	66	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	3100	MPa	ASTM D790
IMPACT [1]			
Izod Impact, unnotched, 23°C	293	J/m	ASTM D4812
Izod Impact, notched, 23°C	48	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	140	°C	ASTM D648
PHYSICAL [1]			
Specific Gravity	1.04	-	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.1	%	ASTM D570
Mold Shrinkage, flow, 24 hrs [2]	0.5 – 0.6	%	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	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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.

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