LNP™ THERMOCOMP™ Compound KF006XXC

KF-1006

DESCRIPTION

LNP THERMOCOMP KF006XXC compound is based on POM (Acetal) copolymer resin containing 30% 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
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, yield	115	MPa	ASTM D638
Tensile Stress, break	115	MPa	ASTM D638
Tensile Strain, yield	2	%	ASTM D638
Tensile Strain, break	2	%	ASTM D638
Tensile Modulus, 50 mm/min	11030	MPa	ASTM D638
Flexural Stress	172	MPa	ASTM D790
Flexural Modulus	9650	MPa	ASTM D790
Tensile Stress, yield	121	MPa	ISO 527
Tensile Stress, break	121	MPa	ISO 527
Tensile Strain, yield	2.1	%	ISO 527
Tensile Strain, break	2.1	%	ISO 527
Tensile Modulus, 1 mm/min	10350	MPa	ISO 527
Flexural Stress	176	MPa	ISO 178
Flexural Modulus	9000	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched, 23°C	640	J/m	ASTM D4812
Izod Impact, notched, 23°C	53	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	8	J	ASTM D3763
Multiaxial Impact	3	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	41	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
THERMAL [1]			

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT, 0.45 MPa, 3.2 mm, unannealed	162	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	162	°C	ASTM D648
CTE, -40°C to 40°C, flow	3.60E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	8.28E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, flow	3.70E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.20E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	164	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	161	°C	ISO 75/Af
PHYSICAL (1)			
Density	1.64	g/cm³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.2	%	ASTM D570
Mold Shrinkage, flow, 24 hrs (2)	0.5	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs (2)	1.6	%	ASTM D955
Mold Shrinkage, flow, 24 hrs (2)	0.49	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (2)	1.6	%	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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