LNP™ THERMOCOMP™ COMPOUND KF004AL

KF-1004 D LE

DESCRIPTION

LNP THERMOCOMP KF004AL compound is based on Acetal (POM) Homopolymer resin containing 20% glass fiber. Added features of this grade include: Low Extractables.

GENERAL INFORMATION	
Features	Food contact, High stiffness/Strength
Fillers	Glass Fiber
Polymer Types	Acetal (POM) Homopolymer
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Water Management
Consumer	Home Appliances
Packaging	Industrial Packaging, Food & Beverage

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, break	60	MPa	ASTM D638
Tensile Strain, break	3.7	%	ASTM D638
Tensile Modulus, 50 mm/min	8610	MPa	ASTM D638
Flexural Stress	110	MPa	ASTM D790
Flexural Modulus	7580	MPa	ASTM D790
IMPACT [1]			
Izod Impact, notched, 23°C	421	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	149	°C	ASTM D648
PHYSICAL [1]			
Density	1.57	g/cm³	ASTM D792
Mold Shrinkage, flow, 24 hrs [2]	0.4	%	ASTM D955
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	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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