

Product Texts

LNP THERMOCOMP KF002XXP compound is based on POM (Acetal) copolymer resin containing 10% glass fiber.

Processing/Physical Characteristics

	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.2	%	ISO 294-4, 2577
Molding shrinkage, normal	1.3	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	1.2	mm/mm	ASTM D 955
Mold Shrinkage, TD	1.3	mm/mm	ASTM D 955

Mechanical properties

	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	5400	MPa	ISO 527
Stress at break	86	MPa	ISO 527
Strain at break	3.4	%	ISO 527
Flexural modulus	5400	MPa	ISO 178
Flexural strength	137	MPa	ISO 178
Izod impact strength, +23°C, 4mm	33	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	5	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	4750	MPa	ASTM D 638
Tensile Strength at Break	84	MPa	ASTM D 638
Elongation at Break	3.2	%	ASTM D 638
Flexural Modulus	4610	MPa	ASTM D 790
Flexural Strength	124	MPa	ASTM D 790
Izod Impact notched, 1/8 in	48	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	448	J/m	ASTM D 256

Thermal properties

	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	161	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 66 psi	164	°C	ASTM D 648
DTUL @ 264 psi	161	°C	ASTM D 648

Other properties

	Value	Unit	Test Standard
Humidity absorption	0.35	%	Sim. to ISO 62
Density	1450	kg/m ³	ISO 1183
Water Absorption, 24hr	0.1	%	ASTM D 570
Density	1450	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding

	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Melt temperature	200 - 215	°C	-
Mold temperature	80 - 110	°C	-
Zone 1	175 - 190	°C	-
Zone 2	195 - 205	°C	-
Zone 3	210 - 220	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.2 - 0.3	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific