

**Product Texts**

LNP THERMOCOMP KX97390 compound is based on POM (Acetal) copolymer resin containing 10% glass fiber.

**Processing/Physical Characteristics**

	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	1.2	%	ISO 294-4, 2577
Molding shrinkage, normal	1.2	%	ISO 294-4, 2577
<b>ASTM Data</b>			
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
<b>ISO Data</b>			
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 <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	5	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
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	427	J/m	ASTM D 256

**Thermal properties**

	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	161	°C	ISO 75-1/-2
<b>ASTM Data</b>			
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 <sup>3</sup>	ISO 1183
Water Absorption, 24hr	0.1	%	ASTM D 570
Density	1450	kg/m <sup>3</sup>	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