

Product Texts

LNP THERMOCOMP KF006XXC compound is based on POM (Acetal) copolymer resin containing 30% glass fiber.

Processing/Physical Characteristics

	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	1.6	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	0.5	mm/mm	ASTM D 955
Mold Shrinkage, TD	1.6	mm/mm	ASTM D 955

Mechanical properties

	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	10400	MPa	ISO 527
Yield stress	121	MPa	ISO 527
Yield strain	2.1	%	ISO 527
Stress at break	121	MPa	ISO 527
Strain at break	2.1	%	ISO 527
Flexural modulus	9000	MPa	ISO 178
Flexural strength	176	MPa	ISO 178
Izod impact strength, +23°C, 4mm	41	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	7	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	11030	MPa	ASTM D 638
Tensile Strength at Yield	115	MPa	ASTM D 638
Tensile Strength at Break	115	MPa	ASTM D 638
Elongation at Yield	2	%	ASTM D 638
Elongation at Break	2	%	ASTM D 638
Flexural Modulus	9650	MPa	ASTM D 790
Flexural Strength	172	MPa	ASTM D 790
Izod Impact notched, 1/8 in	53	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	640	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
Temp. of deflection under load, 0.45 MPa	164	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 66 psi	162	°C	ASTM D 648
DTUL @ 264 psi	162	°C	ASTM D 648

Other properties

	Value	Unit	Test Standard
Density	1640	kg/m ³	ISO 1183
Water Absorption, 24hr	0.2	%	ASTM D 570
Density	1640	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