LNP™ THERMOCOMP™ Compound MF006SXP

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound MFX-1006
Product reorder name: MF006SXP

LNP THERMOCOMP™ MF006SXP is a compound based on Polypropylene resin containing 30% Glass Fiber. Added features of this material include: Chemically Coupled.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	890	kgf/cm²	ASTM D 638
Tensile Strain, break	3	%	ASTM D 638
Tensile Modulus, 50 mm/min	74500	kgf/cm²	ASTM D 638
Flexural Stress	1410	kgf/cm²	ASTM D 790
Flexural Modulus	63200	kgf/cm²	ASTM D 790
Tensile Stress, break	91	MPa	ISO 527
Tensile Strain, break	3.2	%	ISO 527
Tensile Modulus, 1 mm/min	7600	MPa	ISO 527
Flexural Stress	159	MPa	ISO 178
Flexural Modulus	8700	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	71	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	11	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	37	cm-kgf	ASTM D 3763
Multiaxial Impact	27	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	45	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	11	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	160	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	150	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.64E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.97E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	2.64E-05	1/°C	ISO 11359-2

LNP™ THERMOCOMP™ Compound MF006SXP

Americas: COMMERCIAL

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
THERMAL			
CTE, -40°C to 40°C, xflow	5.98E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	152	°C	ISO 75/Af
PHYSICAL			
Density	1.134	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.02	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.5	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.96	%	ISO 294
Density	1.13	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.03	%	ISO 62

LNP™ THERMOCOMP™ Compound MF006SXP

Americas: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Melt Temperature	225 - 250	°C
Front - Zone 3 Temperature	240 - 250	°C
Middle - Zone 2 Temperature	215 - 225	°C
Rear - Zone 1 Temperature	195 - 205	°C
Mold Temperature	30 - 50	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm