



## LNP™ THERMOTUF™ Compound MX00619

### Americas: COMMERCIAL

Also known as: LNP™ THERMOTUF™ Compound PDX-M-00619

Product reorder name: MX00619

LNP THERMOTUF MX00619 is a compound based on Polypropylene resin containing Proprietary Filler(s).

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, break	380	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, break	2.6	%	ASTM D 638
Tensile Modulus, 50 mm/min	319800	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress	560	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus	28600	kgf/cm <sup>2</sup>	ASTM D 790
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	34	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	9	cm-kgf/cm	ASTM D 256
<b>THERMAL</b>			
HDT, 1.82 MPa, 3.2mm, unannealed	137	°C	ASTM D 648
<b>PHYSICAL</b>			
Density	0.99	g/cm <sup>3</sup>	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.2	%	ASTM D 955

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.  
(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.  
(4) Internal measurements according to UL standards.  
(5) 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.  
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
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

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