



LNP™ THERMOTUF™ Compound WF003I

Americas: COMMERCIAL

Also known as: LNP™ THERMOTUF™ Compound WF-1003 HI

Product reorder name: WF003I

LNP THERMOTUF™ WF003I is a compound based on PBT resin containing 15% Glass Fiber. Added features of this material include: High Impact.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	810	kgf/cm ²	ASTM D 638
Flexural Stress	1370	kgf/cm ²	ASTM D 790
Flexural Modulus	46700	kgf/cm ²	ASTM D 790
Tensile Stress, yield	78	MPa	ISO 527
Tensile Stress, break	76	MPa	ISO 527
Tensile Strain, yield	3	%	ISO 527
Tensile Strain, break	4	%	ISO 527
Tensile Modulus, 1 mm/min	5000	MPa	ISO 527
Flexural Stress	130	MPa	ISO 178
Flexural Modulus	4710	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	73	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	13	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	124	cm-kgf	ASTM D 3763
Multiaxial Impact	43	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	46	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	13	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	201	°C	ASTM D 648
PHYSICAL			
Density	1.374	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.09	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1	%	ASTM D 955



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PHYSICAL			
Mold Shrinkage, flow, 24 hrs (5)	0.75	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.95	%	ISO 294
Density	1.37	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	4	hrs
Maximum Moisture Content	0.05	%
Melt Temperature	240 - 265	°C
Front - Zone 3 Temperature	260 - 270	°C
Middle - Zone 2 Temperature	245 - 255	°C
Rear - Zone 1 Temperature	220 - 230	°C
Mold Temperature	80 - 100	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm