+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

LNP™ THERMOCOMP™ Compound KF002L

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound KF-1002 LE
Product reorder name: KF002L

LNP THERMOCOMP KF002L is a compound based on Acetal Homopolymer resin containing 10% Glass Fiber. Added features of this material include: Low Extractible.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	670	kgf/cm²	ASTM D 638
Tensile Stress, break	640	kgf/cm²	ASTM D 638
Tensile Strain, yield	2.2	%	ASTM D 638
Tensile Strain, break	3.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	63200	kgf/cm²	ASTM D 638
Flexural Stress	1050	kgf/cm²	ASTM D 790
Flexural Modulus	49200	kgf/cm²	ASTM D 790
Tensile Stress, yield	65	MPa	ISO 527
Tensile Stress, break	63	MPa	ISO 527
Tensile Strain, yield	2.1	%	ISO 527
Tensile Strain, break	3.2	%	ISO 527
Tensile Modulus, 1 mm/min	5600	MPa	ISO 527
Flexural Stress	105	MPa	ISO 178
Flexural Modulus	4400	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	39	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	65	cm-kgf	ASTM D 3763
Multiaxial Impact	23	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	26	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	162	°C	ASTM D 648

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TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	155	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.08E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.4E-06	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	1.12E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.05E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	162	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	148	°C	ISO 75/Af
PHYSICAL			
Density	1.49	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	1.6 - 1.8	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1.5 - 1.7	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	1.7	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	1.6	%	ISO 294
Density	1.49	g/cm³	ISO 1183

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Melt Temperature	200 - 215	°C
Front - Zone 3 Temperature	210 - 220	°C
Middle - Zone 2 Temperature	195 - 205	°C
Rear - Zone 1 Temperature	175 - 190	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm