



## LNP™ THERMOCOMP™ Compound KF004

### Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound KF-1004

Product reorder name: KF004

LNP THERMOCOMP™ KF004 is a compound based on Acetal Copolymer resin containing 20% Glass Fiber.

| TYPICAL PROPERTIES <sup>1</sup>  | TYPICAL VALUE | Unit                | Standard    |
|----------------------------------|---------------|---------------------|-------------|
| <b>MECHANICAL</b>                |               |                     |             |
| Tensile Stress, break            | 1110          | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Strain, break            | 2.3           | %                   | ASTM D 638  |
| Flexural Stress                  | 1900          | kgf/cm <sup>2</sup> | ASTM D 790  |
| Flexural Modulus                 | 83600         | kgf/cm <sup>2</sup> | ASTM D 790  |
| <b>IMPACT</b>                    |               |                     |             |
| Izod Impact, unnotched, 23°C     | 59            | cm-kgf/cm           | ASTM D 4812 |
| Izod Impact, notched, 23°C       | 6             | cm-kgf/cm           | ASTM D 256  |
| <b>THERMAL</b>                   |               |                     |             |
| HDT, 1.82 MPa, 3.2mm, unannealed | 162           | °C                  | ASTM D 648  |
| <b>PHYSICAL</b>                  |               |                     |             |
| Density                          | 1.56          | g/cm <sup>3</sup>   | ASTM D 792  |



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