



## LNP™ THERMOCOMP™ Compound MX06403

### Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound MF-1004 HS UV HP

Product reorder name: MX06403

LNP THERMOCOMP MX06403 is a compound based on Polypropylene resin containing 20% Glass Fiber. Added features of this material include: Heat Stabilized, UV Stabilized.

| TYPICAL PROPERTIES <sup>1</sup>              | TYPICAL VALUE | Unit                | Standard    |
|----------------------------------------------|---------------|---------------------|-------------|
| <b>MECHANICAL</b>                            |               |                     |             |
| Tensile Stress, brk, Type I, 5 mm/min        | 500           | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Strain, brk, Type I, 5 mm/min        | 3 - 4         | %                   | ASTM D 638  |
| Flexural Stress, brk, 1.3 mm/min, 50 mm span | 670           | kgf/cm <sup>2</sup> | ASTM D 790  |
| Flexural Modulus, 1.3 mm/min, 50 mm span     | 31600         | kgf/cm <sup>2</sup> | ASTM D 790  |
| <b>IMPACT</b>                                |               |                     |             |
| Izod Impact, unnotched, 23°C                 | 29            | cm-kgf/cm           | ASTM D 4812 |
| Izod Impact, notched, 23°C                   | 4             | cm-kgf/cm           | ASTM D 256  |
| <b>THERMAL</b>                               |               |                     |             |
| HDT, 1.82 MPa, 3.2mm, unannealed             | 140           | °C                  | ASTM D 648  |
| <b>PHYSICAL</b>                              |               |                     |             |
| Specific Gravity                             | 1.04          | -                   | ASTM D 792  |
| Moisture Absorption, 50% RH, 24 hrs          | 0.1           | %                   | ASTM D 570  |
| Mold Shrinkage, flow, 24 hrs (5)             | 0.5 - 0.6     | %                   | ASTM D 955  |



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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  |