



LNP™ THERMOCOMP™ Compound BF004

Americas: COMMERCIAL

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

Product reorder name: BF004

LNP THERMOCOMP BF004 is a compound based on SAN resin containing 20% Glass Fiber.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1100	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	84200	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1420	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	77300	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	103	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.6	%	ISO 527
Tensile Modulus, 1 mm/min	8220	MPa	ISO 527
Flexural Modulus, 2 mm/min	7280	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	19	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
Multiaxial Impact	17	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	76	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	12	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	3	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	104	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	100	°C	ASTM D 648
CTE, -30°C to 30°C, flow	4.4E+01	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	4.73E+01	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	104	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	100	°C	ISO 75/Af



LNP™ THERMOCOMP™ Compound BF004

Americas: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Density	1.22	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.19	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.1 - 0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.3 - 0.5	%	ASTM D 955
Density	1.22	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.26	%	ISO 62



LNP™ THERMOCOMP™ Compound BF004

Americas: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15	%
Melt Temperature	260	°C
Front - Zone 3 Temperature	275 - 290	°C
Middle - Zone 2 Temperature	245 - 255	°C
Rear - Zone 1 Temperature	205 - 215	°C
Mold Temperature	80 - 95	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm