

LNP™ THERMOCOMP™ KB006 compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP THERMOCOMP KB006 is a compound based on Acetal containing 30% Glass Bead.

Also known as: LNP* THERMOCOMP* Compound KB-1006

Product reorder name: KB006

General Information			
Filler / Reinforcement	Glass Bead,30% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.64	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	1.0 to 4.0	%	
Across Flow : 24 hr	1.0 to 4.0	%	
Water Absorption			
24 hr, 50% RH	0.20	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Break ¹	34.0	MPa	ASTM D638
Break	37.0	MPa	ISO 527-2/5
Tensile Elongation			
Break ²	20	%	ASTM D638
Break	20	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ³	4000	MPa	ASTM D790
-- ⁴	4320	MPa	ISO 178
Flexural Stress			
--	65.0	MPa	ISO 178
Break, 50.0 mm Span ⁵	43.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁶ (23°C)	4.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	370	J/m	ASTM D4812
23°C ⁷	25	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	155	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁸	152	°C	ISO 75-2/Bf

1.8 MPa, Unannealed, 3.20 mm	103	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁹	107	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	8.3E-5	cm/cm/°C	
Transverse : -30 to 30°C	8.3E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	177 to 188	°C	
Middle Temperature	193 to 204	°C	
Front Temperature	210 to 221	°C	
Processing (Melt) Temp	199 to 216	°C	
Mold Temperature	82.2 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	Type I, 5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	1.3 mm/min		
4.	2.0 mm/min		
5.	1.3 mm/min		
6.	80*10*4		
7.	80*10*4		
8.	80*10*4 mm		
9.	80*10*4 mm		

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