

LNP™ THERMOCOMP™ 2F004 compound

Ethylene Tetrafluoroethylene Copolymer

SABIC Innovative Plastics

Message:

LNP FP-EF-1004 is a fluoropolymer compound based on ETFE resin containing 20% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound FP-EF-1004

Product reorder name: 2F004

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.85	g/cm ³	
--	1.84	g/cm ³	
Molding Shrinkage			ASTM D955
Flow : 24 hr	1.0 to 3.0	%	
Across Flow : 24 hr	2.0 to 4.0	%	
Water Absorption			
24 hr, 50% RH	0.020	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.010	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4870	MPa	ASTM D638
--	4410	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	54.0	MPa	ASTM D638
Yield	52.0	MPa	ISO 527-2/5
Break ³	49.0	MPa	ASTM D638
Break	51.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	9.4	%	ASTM D638
Yield	9.1	%	ISO 527-2/5
Break ⁵	11	%	ASTM D638
Break	9.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	4020	MPa	ASTM D790
-- ⁷	3780	MPa	ISO 178
Flexural Stress	72.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	550	J/m	ASTM D256
23°C ⁸	45	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1500	J/m	ASTM D4812
23°C ⁹	97	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	21.0	J	ASTM D3763
--	10.8	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	240	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	219	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	132	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	112	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	5.9E-5	cm/cm/°C	
Transverse : -30 to 30°C	7.6E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	120 to 150	°C	
Drying Time	4.0	hr	
Rear Temperature	280 to 300	°C	
Middle Temperature	300 to 325	°C	
Front Temperature	325 to 340	°C	
Processing (Melt) Temp	315	°C	
Mold Temperature	90.0 to 120	°C	
Back Pressure	0.170 to 0.340	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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