

LNP™ THERMOCOMP™ KF005 compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* KF005 is a compound based on Acetal Copolymer resin containing 25% Glass Fiber. Added features of this material include: Chemically Coupled.

Also known as: LNP* THERMOCOMP* Compound KFX-1005

Product reorder name: KF005

General Information			
Filler / Reinforcement	Glass Fiber,25% Filler by Weight		
Features	Chemically Coupled		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.60	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.60 to 0.90	%	
Across Flow : 24 hr	1.0 to 4.0	%	
Water Absorption			
24 hr, 50% RH	0.28	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.28	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	12900	MPa	ASTM D638
Tensile Strength			
Break ²	107	MPa	ASTM D638
Break	100	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	4.2	%	ASTM D638
Break	3.5	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	545	MPa	ASTM D790
-- ⁵	10200	MPa	ISO 178
Flexural Strength ⁶ (Break, 50.0 mm Span)	38.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	70	J/m	ASTM D256
23°C ⁷	5.6	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	700	J/m	ASTM D4812
23°C ⁸	39	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	163	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	164	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	162	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	161	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	7.1E-5	cm/cm/°C	
Transverse : -30 to 30°C	7.3E-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.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		
10.	80*10*4 mm		

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