

LNP™ THERMOCOMP™ MX06402H

compound

Polypropylene

SABIC Innovative Plastics

Message:

LNP THERMOCOMP MX06402H is a compound based on Polypropylene resin containing 20% Glass Fiber. Added features of this material include: Heat Stabilized, Low Extractable.

Also known as: LNP* THERMOCOMP* Compound MF-1004 HS LE

Product reorder name: MX06402H

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
	Low Extractables		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.06	g/cm ³	ASTM D792
--	1.05	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.70 to 0.90	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	9.0E-3	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.010	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6400	MPa	ASTM D638
--	5350	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	38.0	MPa	ASTM D638
Yield	37.0	MPa	ISO 527-2/5
Break ³	34.9	MPa	ASTM D638
Break	35.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.1	%	ASTM D638
Yield	1.8	%	ISO 527-2/5
Break ⁵	3.5	%	ASTM D638

Break	2.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	4700	MPa	ASTM D790
-- ⁷	4700	MPa	ISO 178
Flexural Stress			
--	65.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	66.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	49	J/m	ASTM D256
23°C ⁹	4.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	200	J/m	ASTM D4812
23°C ¹⁰	14	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	12.0	J	ASTM D3763
--	2.30	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	143	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	134	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	103	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	95.0	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	4.5E-5	cm/cm/°C	
Transverse : -30 to 30°C	1.0E-4	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	193 to 204	°C	
Middle Temperature	216 to 227	°C	
Front Temperature	238 to 249	°C	
Processing (Melt) Temp	227 to 249	°C	
Mold Temperature	32.2 to 48.9	°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.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		

6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4
10.	80*10*4
11.	80*10*4 mm
12.	80*10*4 mm

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