

LNP™ THERMOCOMP™ KFZ24XXP compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP THERMOCOMP KFZ24XXP is a compound based on Acetal Copolymer resin containing 20% Glass Fiber, 10% Milled Glass. Added features of this material include: Low Warpage, Chemically Coupled, Internally Lubricated.
Also known as: LNP* THERMOCOMP* Compound KFX-1006 MG
Product reorder name: KFZ24XXP

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
	Milled Glass Fiber,10% Filler by Weight		
Additive	Lubricant		
Features	Chemically Coupled		
	Low Warpage		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.64	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.70	%	ASTM D955
Across Flow : 24 hr	1.3	%	ASTM D955, ISO 294-4
Flow : 24 hr	0.66	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	8550	MPa	ASTM D638
--	8900	MPa	ISO 527-2/1
Tensile Strength			
Break	105	MPa	ASTM D638
Break	110	MPa	ISO 527-2
Tensile Elongation			
Break	2.5	%	ASTM D638
Break	2.6	%	ISO 527-2
Flexural Modulus			
--	7580	MPa	ASTM D790
--	9400	MPa	ISO 178
Flexural Strength			
--	165	MPa	ASTM D790

--	171	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	64	J/m	ASTM D256
23°C ²	6.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	530	J/m	ASTM D4812
23°C ³	37	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	10.3	J	ASTM D3763
--	2.24	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	164	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	161	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	160	°C	ISO 75-2/Af
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.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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