

LNP™ THERMOCOMP™ KF002 compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* KF002 is a compound based on Acetal Copolymer resin containing 10% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound KF-1002

Product reorder name: KF002

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955, ISO 294-4
Flow : 24 hr	1.2	%	
Across Flow : 24 hr	1.3	%	
Water Absorption			
24 hr, 50% RH	0.19	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.35	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4760	MPa	ASTM D638
--	5400	MPa	ISO 527-2/1
Tensile Strength			
Break	84.5	MPa	ASTM D638
Break	86.4	MPa	ISO 527-2
Tensile Elongation			
Break	3.2	%	ASTM D638
Break	3.4	%	ISO 527-2
Flexural Modulus			
--	4620	MPa	ASTM D790
--	5400	MPa	ISO 178
Flexural Strength			
--	129	MPa	ASTM D790
--	137	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	48	J/m	ASTM D256
23°C ²	5.3	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	450	J/m	ASTM D4812

23°C ³	33	kJ/m ²	ISO 180/1U
Multi-Axial Instrumented Impact Energy	1.45	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	162	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	161	°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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

