

LNP™ THERMOCOMP™ KFB11 compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP THERMOCOMP KFB11 is a compound based on Acetal Copolymer resin containing Glass Fiber, Milled Glass. Added features of this material include: Low Warpage, Chemically Coupled.
Also known as: LNP* THERMOCOMP* Compound KFX-1002 MG
Product reorder name: KFB11

General Information			
Filler / Reinforcement	Grinding Glass/Fiberglass		
Features	Low warpage		
	Chemical coupling		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	1.0 - 3.0	%	ASTM D955
Transverse flow: 24 hours	1.0 - 3.0	%	ASTM D955
Vertical flow direction: 24 hours	1.7	%	ISO 294-4
Flow direction: 24 hours	1.9	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.20	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4140	MPa	ASTM D638
--	4100	MPa	ISO 527-2/1
Tensile Strength			
Yield	64.8	MPa	ASTM D638
Yield	65.0	MPa	ISO 527-2
Fracture	62.1	MPa	ASTM D638
Fracture	60.0	MPa	ISO 527-2
Tensile Elongation			
Yield	4.0	%	ASTM D638, ISO 527-2
Fracture	5.7	%	ASTM D638
Fracture	7.1	%	ISO 527-2
Flexural Modulus			
--	3450	MPa	ASTM D790
--	3000	MPa	ISO 178
Flexural Stress	91.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	53	J/m	ASTM D256
23°C ²	5.4	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	530	J/m	ASTM D4812
23°C ³	35	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	6.60	J	ASTM D3763
--	1.70	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	163	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁴	161	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	153	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁵	150	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	1.1E-4	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	8.6E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	177 - 188	°C	
Middle Temperature	193 - 204	°C	
Front Temperature	210 - 221	°C	
Processing (Melt) Temp	199 - 216	°C	
Mold Temperature	82.2 - 110	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		
5.	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

