

LNP™ THERMOCOMP™ KF006XXC

compound

Acetal (POM) Copolymer
SABIC Innovative Plastics

Message:

LNP THERMOCOMP KF006XXC is a compound based on Acetal Copolymer resin containing 30% Glass Fiber.
Also known as: LNP* THERMOCOMP* Compound KF-1006
Product reorder name: KF006XXC

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
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	0.50	%	ASTM D955
Across Flow : 24 hr	1.6	%	ASTM D955, ISO 294-4
Flow : 24 hr	0.49	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.20	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- 1	11000	MPa	ASTM D638
--	10400	MPa	ISO 527-2/1
Tensile Strength			
Yield	116	MPa	ASTM D638
Yield	121	MPa	ISO 527-2
Break	116	MPa	ASTM D638
Break	121	MPa	ISO 527-2
Tensile Elongation			
Yield	2.0	%	ASTM D638
Yield	2.1	%	ISO 527-2
Break	2.0	%	ASTM D638
Break	2.1	%	ISO 527-2
Flexural Modulus			
--	9650	MPa	ASTM D790
--	9000	MPa	ISO 178
Flexural Strength			
--	172	MPa	ASTM D790
--	176	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	53	J/m	ASTM D256
23°C ²	7.1	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	640	J/m	ASTM D4812
23°C ³	41	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	8.30	J	ASTM D3763
--	3.30	J	ISO 6603-2
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 ⁴	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 ⁵	161	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	8.3E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	8.2E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	3.6E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	3.7E-5	cm/cm/°C	ISO 11359-2
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		
5.	80*10*4 mm		

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