

LNP* Thermocomp* Compound MF004SU

Americas: COMMERCIAL

LNP* Thermocomp* MF004SU is a compound based on Polypropylene containing Glass Fiber. Characteristics of this grade are: Heat Stabilized and Chemically Coupled.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	670	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3.1	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1080	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	42100	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	54	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	145	°C	ASTM D 648
PHYSICAL			
Density	1.04	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1	%	ASTM D 955

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176;C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Melt Temperature	225 - 250	°C
Front - Zone 3 Temperature	240 - 250	°C
Middle - Zone 2 Temperature	215 - 225	°C
Rear - Zone 1 Temperature	195 - 205	°C
Mold Temperature	30 - 50	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

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