

LNP* Thermocomp* Compound KF004

Americas: COMMERCIAL

Also known as: KF-1004
Product Reorder Name: KF004

LNP THERMOCOMP* KF004 is a compound based on Acetal Copolymer resin containing Glass Fiber.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, break	108	MPa	ASTM D 638
Tensile Strain, break	2.3	%	ASTM D 638
Flexural Stress	186	MPa	ASTM D 790
Flexural Modulus	8200	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	587	J/m	ASTM D 4812
Izod Impact, notched, 23°C	64	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	162	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Density	1.56	g/cm ³	ASTM D 792

Source GMD, last updated:10/02/2004

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Melt Temperature	200 - 215	°C
Front - Zone 3 Temperature	210 - 220	°C
Middle - Zone 2 Temperature	195 - 205	°C
Rear - Zone 1 Temperature	175 - 190	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

Source GMD, last updated:10/02/2004

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(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°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.

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