



LNP™ THERMOCOMP™ Compound KF004AL

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound KF-1004 D LE
Product reorder name: KF004AL

LNP THERMOCOMP KF004AL is a compound based on Acetal Homopolymer resin containing 20% Glass Fiber. Added features of this material include: Low Extractible.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	610	kgf/cm ²	ASTM D 638
Tensile Strain, break	3.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	87800	kgf/cm ²	ASTM D 638
Flexural Stress	1120	kgf/cm ²	ASTM D 790
Flexural Modulus	77300	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	43	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	149	°C	ASTM D 648
PHYSICAL			
Density	1.57	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.4	%	ASTM D 955



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PROCESSING PARAMETERS	TYPICAL 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