



LNP™ THERMOCOMP™ Compound KF005

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound KFX-1005

Product reorder name: KF005

LNP THERMOCOMP™ KF005 is a compound based on Acetal Copolymer resin containing 25% Glass Fiber. Added features of this material include:
Chemically Coupled.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1090	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	131700	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	390	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	5500	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	100	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3.5	%	ISO 527
Flexural Modulus, 2 mm/min	10160	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	71	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	38	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	163	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	162	°C	ASTM D 648
CTE, -30°C to 30°C, flow	7.1E+01	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	7.3E+01	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	164	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	161	°C	ISO 75/Af
PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.28	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.6 - 0.9	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1 - 4	%	ASTM D 955



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Density	1.6	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.28	%	ISO 62



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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