



## LNP™ THERMOCOMP™ Compound KX97390

### Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound PDX-K-97390

Product reorder name: KX97390

LNP THERMOCOMP™ KX97390 is a compound based on Acetal Copolymer resin containing Glass Fiber. Added features of this material include: Chemically Coupled.

| TYPICAL PROPERTIES <sup>1</sup>       | TYPICAL VALUE | Unit                | Standard    |
|---------------------------------------|---------------|---------------------|-------------|
| <b>MECHANICAL</b>                     |               |                     |             |
| Tensile Stress, break                 | 850           | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Strain, break                 | 3.2           | %                   | ASTM D 638  |
| Tensile Modulus, 50 mm/min            | 48500         | kgf/cm <sup>2</sup> | ASTM D 638  |
| Flexural Stress                       | 1260          | kgf/cm <sup>2</sup> | ASTM D 790  |
| Flexural Modulus                      | 47100         | kgf/cm <sup>2</sup> | ASTM D 790  |
| Tensile Stress, break                 | 86            | MPa                 | ISO 527     |
| Tensile Strain, break                 | 3.4           | %                   | ISO 527     |
| Tensile Modulus, 1 mm/min             | 5400          | MPa                 | ISO 527     |
| Flexural Stress                       | 137           | MPa                 | ISO 178     |
| Flexural Modulus                      | 5400          | MPa                 | ISO 178     |
| <b>IMPACT</b>                         |               |                     |             |
| Izod Impact, unnotched, 23°C          | 43            | cm-kgf/cm           | ASTM D 4812 |
| Izod Impact, notched, 23°C            | 4             | cm-kgf/cm           | ASTM D 256  |
| Multiaxial Impact                     | 10            | cm-kgf              | ISO 6603    |
| Izod Impact, unnotched 80*10*4 +23°C  | 33            | kJ/m <sup>2</sup>   | ISO 180/1U  |
| Izod Impact, notched 80*10*4 +23°C    | 5             | kJ/m <sup>2</sup>   | ISO 180/1A  |
| <b>THERMAL</b>                        |               |                     |             |
| HDT, 0.45 MPa, 3.2 mm, unannealed     | 164           | °C                  | ASTM D 648  |
| HDT, 1.82 MPa, 3.2mm, unannealed      | 161           | °C                  | ASTM D 648  |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm | 161           | °C                  | ISO 75/Af   |
| <b>PHYSICAL</b>                       |               |                     |             |
| Density                               | 1.45          | g/cm <sup>3</sup>   | ASTM D 792  |
| Moisture Absorption, 50% RH, 24 hrs   | 0.1           | %                   | ASTM D 570  |
| Mold Shrinkage, flow, 24 hrs (5)      | 1.2           | %                   | ASTM D 955  |



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| PHYSICAL                            |               |                   |            |
| Mold Shrinkage, xflow, 24 hrs (5)   | 1.3           | %                 | ASTM D 955 |
| Mold Shrinkage, flow, 24 hrs (5)    | 1.16          | %                 | ISO 294    |
| Mold Shrinkage, xflow, 24 hrs (5)   | 1.24          | %                 | ISO 294    |
| Density                             | 1.45          | g/cm <sup>3</sup> | ISO 1183   |
| Moisture Absorption (23°C / 50% RH) | 0.35          | %                 | ISO 62     |



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| PROCESSING PARAMETERS       | TYPICAL VALUE | Unit |
|-----------------------------|---------------|------|
| <b>Injection Molding</b>    |               |      |
| 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  |