



LNP™ THERMOCOMP™ Compound KFZ24XXP

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound KFX-1006 MG

Product reorder name: KFZ24XXP

LNP THERMOCOMP KFZ24XXP is a compound based on Acetal Copolymer resin containing 20% Glass Fiber, 10% Milled Glass. Added features of this material include: Low Warpage, Chemically Coupled, Internally Lubricated.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1070	kgf/cm ²	ASTM D 638
Tensile Strain, break	2.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	87100	kgf/cm ²	ASTM D 638
Flexural Stress	1680	kgf/cm ²	ASTM D 790
Flexural Modulus	77300	kgf/cm ²	ASTM D 790
Tensile Stress, break	109	MPa	ISO 527
Tensile Strain, break	2.6	%	ISO 527
Tensile Modulus, 1 mm/min	8900	MPa	ISO 527
Flexural Stress	171	MPa	ISO 178
Flexural Modulus	9400	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	54	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	105	cm-kgf	ASTM D 3763
Multiaxial Impact	22	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	36	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	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	161	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	160	°C	ISO 75/Af
PHYSICAL			
Density	1.64	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Mold Shrinkage, flow, 24 hrs (5)	0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1.3	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.66	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	1.3	%	ISO 294
Density	1.64	g/cm ³	ISO 1183



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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