



LNP™ THERMOTUF™ Compound MF004AI

Americas: COMMERCIAL

Also known as: LNP™ THERMOTUF™ Compound MF-1004 HI

Product reorder name: MF004AI

LNP THERMOTUF MF004AI is a compound based on Polypropylene resin containing 20% Glass Fiber. Added features of this material include: High Impact.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	400	kgf/cm ²	ASTM D 638
Tensile Strain, break	4.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	49200	kgf/cm ²	ASTM D 638
Flexural Stress	420	kgf/cm ²	ASTM D 790
Flexural Modulus	28100	kgf/cm ²	ASTM D 790
Tensile Stress, break	37	MPa	ISO 527
Tensile Strain, break	4.5	%	ISO 527
Tensile Modulus, 1 mm/min	4940	MPa	ISO 527
Flexural Stress	46	MPa	ISO 178
Flexural Modulus	3000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	44	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	17	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	28	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	150	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	108	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.06E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.84E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	1.05E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.8E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	144	°C	ISO 75/Bf





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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	104	°C	ISO 75/Af
PHYSICAL			
Density	1.03	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	1.1 - 1.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1.1 - 1.3	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	1.2	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	1.2	%	ISO 294
Density	1.03	g/cm³	ISO 1183





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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Melt Temperature	225 - 250	°C
Front - Zone 3 Temperature	240 - 250	°C
Middle - Zone 2 Temperature	215 - 225	°C
Rear - Zone 1 Temperature	195 - 205	°C
Mold Temperature	30 - 50	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

