

LNP* Thermocomp* Compound 4X08423
Americas: COMMERCIAL

LNP* Thermocomp* 4X08423 is a compound based on Perfluoroalkoxy Polymer (PFA) containing Glass Fiber.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	350	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.9	%	ASTM D 638
Tensile Modulus, 50 mm/min	52300	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	460	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	29400	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	32	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	12	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	169	°C	ASTM D 648
PHYSICAL			
Specific Gravity	2.2	-	ASTM D 792

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176;C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	150	°C
Drying Time	4	hrs
Drying Time (Cumulative)	4	hrs
Melt Temperature	360	°C
Nozzle Temperature	365	°C
Front - Zone 3 Temperature	360	°C
Middle - Zone 2 Temperature	360	°C
Rear - Zone 1 Temperature	360	°C
Hopper Temperature	45	°C
Mold Temperature	150	°C
Back Pressure	3.5	MPa
Screw Speed	60	rpm

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