

## LNP\* Thermocomp\* Compound MF006SU

### Americas: COMMERCIAL

LNP\* Thermocomp\* MF006SU is a compound based on Polypropylene containing Glass Fiber. Characteristics of this grade are: Heat Stabilized and Chemically Coupled.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, brk, Type I, 5 mm/min	820	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	147500	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1330	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	63200	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, break, 5 mm/min	80	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3	%	ISO 527
Tensile Modulus, 1 mm/min	9120	MPa	ISO 527
Flexural Stress	135	MPa	ISO 178
Flexural Modulus, 2 mm/min	6800	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	61	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	37	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	157	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	133	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.8E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.9E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	4.4E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	161	°C	ISO 75/Bf

(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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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>THERMAL</b>			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Af
<b>PHYSICAL</b>			
Density	1.12	g/cm <sup>3</sup>	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.6 - 0.8	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.9 - 1.1	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.65	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.98	%	ISO 294
Density	1.12	g/cm <sup>3</sup>	ISO 1183

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

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