

LNP* Thermocomp* Compound KB006

Americas: COMMERCIAL

Also known as: THERMOCOMP KB-1006
Product Reorder Name: KB006

LNP* Thermocomp* KB006 is a compound based on Acetal containing Glass Beads.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, brk, Type I, 5 mm/min	34	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	19.8	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	43	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3990	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	37	MPa	ISO 527
Tensile Strain, break, 5 mm/min	20.4	%	ISO 527
Flexural Stress	65	MPa	ISO 178
Flexural Modulus, 2 mm/min	4320	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	374	J/m	ASTM D 4812
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	311	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	218	°C	ASTM D 648
CTE, -30°C to 30°C, flow	8.3E+01	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	8.3E+01	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	152	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	107	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.64	-	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	1 - 4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1 - 4	%	ASTM D 955
Density	1.64	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62

Source GMD, last updated:2009/08/27

Processing

Parameter	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

Source GMD, last updated:2009/08/27

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(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°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.

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