LNP™ THERMOCOMP™ COMPOUND AF006

DESCRIPTION

LNP THERMOCOMP AF006 is a compound based on Acrylonitrile Butadiene Styrene resin containing Glass Fiber.

TYPICAL PROPERTY VALUES

Revision 20191219

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	82	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.4	%	ISO 527
Tensile Modulus, 1 mm/min	7900	MPa	ISO 527
Flexural Stress, break, 2 mm/min	103	MPa	ISO 178
Flexural Modulus, 2 mm/min	6300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	20	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	2.3E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	6.5E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	104	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	98	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	0.12	%	SABIC method
Density	1.26	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.05 – 0.1	%	
Melt Temperature	260	°C	
Front - Zone 3 Temperature	265 – 275	°C	
Middle - Zone 2 Temperature	230 – 245	°C	
Rear - Zone 1 Temperature	205 – 215	°C	
Mold Temperature	70 – 80	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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