LNP™ THERMOCOMP™ COMPOUND AX06472

AX06472
REGION AMERICAS

DESCRIPTION

LNP* Thermocomp* AX06472 is a compound based on ABS containing a clay blend.

TYPICAL PROPERTY VALUES

Revision 20190730

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	62	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Modulus, 50 mm/min	5930	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	96	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	5380	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	240	J/m	ASTM D 4812
Izod Impact, notched, 23°C	42	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	96	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.3	-	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.5	%	ASTM D 955
ELECTRICAL			
Relative Permittivity, 1 GHz	3	-	ASTM D 150
Dissipation Factor, 1 GHz	0.003	-	ASTM D 150
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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