LNP™ THERMOCOMP™ Compound AF006XXZ

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound AF-1006
Product reorder name: AF006XXZ

LNP THERMOCOMP AF006XXZ is a compound based on ABS resin containing 30% Glass Fiber.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	980	kgf/cm²	ASTM D 638
Tensile Strain, break	1.8	%	ASTM D 638
Flexural Stress	1560	kgf/cm²	ASTM D 790
Flexural Modulus	93500	kgf/cm²	ASTM D 790
Tensile Stress, break	83	MPa	ISO 527
Tensile Strain, break	1.7	%	ISO 527
Flexural Stress	119	MPa	ISO 178
Flexural Modulus	8000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	28	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	5	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	102	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	102	°C	ISO 75/Af
PHYSICAL			
Density	1.28	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.2	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.4	%	ASTM D 955

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
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