



LNP™ THERMOCOMP™ Compound AX06472

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound AX06472

Product reorder name: AX06472

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	630	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Modulus, 50 mm/min	60400	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	980	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	54800	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	24	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	4	cm-kgf/cm	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 (5)	0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.5	%	ASTM D 955
ELECTRICAL			
Relative Permittivity, 1 GHz	3	-	ASTM D 150
Dissipation Factor, 1 GHz	0.003	-	ASTM D 150





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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

