

LNP™ THERMOCOMP™ AF004L compound

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

LNP THERMOCOMP AF004L is a compound based on ABS resin containing 20% Glass Fiber. Added feature of this material is: Low Extractible.

Also known as: LNP* THERMOCOMP* Compound AF-1004 LE

Product reorder name: AF004L

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Low Extractables		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
	1.18		
Specific Gravity	1.18	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.10 to 0.30	%	
Across Flow : 24 hr	0.30 to 0.50	%	
Water Absorption			
24 hr, 50% RH	0.23	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.28	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5940	MPa	ASTM D638
--	5670	MPa	ISO 527-2/1
Tensile Strength			
Break ²	77.0	MPa	ASTM D638
Break	72.0	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.1	%	ASTM D638
Break	2.1	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	5400	MPa	ASTM D790
-- ⁵	4920	MPa	ISO 178
Flexural Stress			
--	107	MPa	ISO 178
Yield, 50.0 mm Span ⁶	112	MPa	ASTM D790
Break, 50.0 mm Span ⁷	109	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	82	J/m	ASTM D256
23°C ⁸	7.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	360	J/m	ASTM D4812
23°C ⁹	22	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	11.6	J	ASTM D3763
--	3.34	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	104	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	104	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	99.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	98.9	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	4.9E-5	cm/cm/°C	
Transverse : -30 to 30°C	6.6E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.050 to 0.10	%	
Rear Temperature	204 to 216	°C	
Middle Temperature	232 to 243	°C	
Front Temperature	266 to 277	°C	
Processing (Melt) Temp	260	°C	
Mold Temperature	71.1 to 82.2	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	1.3 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

