

LNP™ THERMOCOMP™ AX04518 compound

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

LNP THERMOCOMP AX04518 is a compound based on ABS resin containing proprietary filler(s).

Also known as: LNP* THERMOCOMP* Compound PDX-A-04518

Product reorder name: AX04518

General Information			
Filler / Reinforcement	Proprietary		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage	ASTM D955		
Flow : 24 hr	0.40 to 0.60	%	
Across Flow : 24 hr	0.60 to 0.80	%	
Water Absorption			
24 hr, 50% RH	0.67	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.40	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6760	MPa	ASTM D638
--	6330	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	78.0	MPa	ASTM D638
Yield	74.0	MPa	ISO 527-2/5
Break ³	78.0	MPa	ASTM D638
Break	74.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	1.9	%	ASTM D638
Yield	1.8	%	ISO 527-2/5
Break ⁵	1.9	%	ASTM D638
Break	1.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	6260	MPa	ASTM D790
-- ⁷	5990	MPa	ISO 178
Flexural Stress			
--	98.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	112	MPa	ASTM D790
Break, 50.0 mm Span ⁹	110	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	52	J/m	ASTM D256
23°C ¹⁰	5.3	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	270	J/m	ASTM D4812
23°C ¹¹	16	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	8.90	J	ASTM D3763
--	2.40	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	119	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	120	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	114	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	115	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	6.0E-5	cm/cm/°C	
Transverse : -30 to 30°C	6.9E-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.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	1.3 mm/min		
10.	80*10*4		
11.	80*10*4		
12.	80*10*4 mm		

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