

LNP™ THERMOCOMP™ AX06472 compound

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

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

Also known as: LNP* THERMOCOMP* Compound AX06472

Product reorder name: AX06472

General Information			
Filler / Reinforcement	Clay		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.40	%	
Across Flow : 24 hr	0.50	%	
Water Absorption (24 hr, 50% RH)	0.20	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	5930	MPa	ASTM D638
Tensile Strength ² (Yield)	62.1	MPa	ASTM D638
Tensile Elongation ³ (Break)	2.0	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	5380	MPa	ASTM D790
Flexural Strength ⁵ (Break, 50.0 mm Span)	96.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	43	J/m	ASTM D256
Unnotched Izod Impact (23°C)	240	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	96.7	°C	ASTM D648
Electrical	Nominal Value		Test Method
Dielectric Constant (1.00 GHz)	3.00		ASTM D150
Dissipation Factor (1.00 GHz)	3.0E-3		ASTM D150
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.	1.3 mm/min	
5.	1.3 mm/min	

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