

LNP™ THERMOCOMP™ CX05470 compound

High Impact Polystyrene

SABIC Innovative Plastics

Message:

LNP THERMOCOMP CX05470 is a compound based on Polystyrene resin containing 20% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound CF-1004 ZS

Product reorder name: CX05470

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.10 to 0.40	%	
Across Flow : 24 hr	0.20 to 0.50	%	
Water Absorption			
24 hr, 50% RH	0.060	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.070	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	7080	MPa	ASTM D638
--	6810	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	51.0	MPa	ASTM D638
Yield	52.0	MPa	ISO 527-2/5
Break	64.8	MPa	ASTM D638
Break ³	51.0	MPa	ASTM D638
Break	52.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	1.2	%	ASTM D638
Yield	1.1	%	ISO 527-2/5
Break	1.2	%	ASTM D638
Break ⁵	1.3	%	ASTM D638
Break	1.1	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	6480	MPa	ASTM D790
--	6340	MPa	ASTM D790
-- ⁷	6320	MPa	ISO 178
Flexural Strength			
--	96.5	MPa	ASTM D790

--	85.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	90.3	MPa	ASTM D790
Break, 50.0 mm Span ⁹	89.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	36	J/m	ASTM D256
23°C ¹⁰	3.4	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	160	J/m	ASTM D4812
23°C ¹¹	9.7	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	8.10	J	ASTM D3763
--	2.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	97.0	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	97.0	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	93.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	92.0	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	6.9E-5	cm/cm/°C	
Transverse : -30 to 30°C	5.6E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	221 to 232	°C	
Middle Temperature	243 to 254	°C	
Front Temperature	266 to 277	°C	
Processing (Melt) Temp	249	°C	
Mold Temperature	37.8 to 65.6	°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
13.	80*10*4 mm

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