

LNP* Thermocomp* Compound AX06472

Americas: COMMERCIAL

Also known as: THERMOCOMP AX06472
Product Reorder Name: AX06472

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

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	62	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Modulus, 50 mm/min	5930	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	96	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	5380	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	240	J/m	ASTM D 4812
Izod Impact, notched, 23°C	42	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	96	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
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	Value	Unit	Standard
Relative Permittivity, 1 GHz	3	-	ASTM D 150
Dissipation Factor, 1 GHz	0.003	-	ASTM D 150

Source GMD, last updated:2009/11/24

Processing

Parameter	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

Source GMD, last updated:2009/11/24

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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