

LNP™ THERMOCOMP™ AX02749 compound

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

LNP THERMOCOMP AX02749 is a compound based on ABS containing proprietary fillers.

Also known as: LNP* THERMOCOMP* Compound PDX-A-02749

Product reorder name: AX02749

General Information			
Filler / Reinforcement	Proprietary		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955, ISO 294-4
Flow : 24 hr	0.20 to 0.50	%	
Across Flow : 24 hr	0.40 to 0.70	%	
Water Absorption (24 hr, 50% RH)	0.25	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6090	MPa	ASTM D638
--	6050	MPa	ISO 527-2/1
Tensile Strength			
Break ²	76.0	MPa	ASTM D638
Break	77.0	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.0	%	ASTM D638
Break	1.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	6080	MPa	ASTM D790
-- ⁵	5970	MPa	ISO 178
Flexural Stress			
--	119	MPa	ISO 178
Break, 50.0 mm Span ⁶	122	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	80	J/m	ASTM D256
23°C ⁷	7.1	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	370	J/m	ASTM D4812
23°C ⁸	24	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			

23°C, Total Energy	13.0	J	ASTM D3763
--	2.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	100	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁹	100	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	5.6E-5	cm/cm/°C	
Transverse : -30 to 30°C	5.2E-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.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		

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