

LNP\* Thermocomp\* Compound AFB42

Americas: COMMERCIAL

LNP\* Thermocomp\* AF-1006 MG is a compound based on ABS containing mixed glass.

Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	28	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	51	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	9400	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	76	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	4920	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	19	MPa	ISO 527
Tensile Stress, break, 5 mm/min	48	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.7	%	ISO 527
Tensile Modulus, 1 mm/min	4750	MPa	ISO 527
Flexural Modulus, 2 mm/min	9440	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	72	J/m	ASTM D 4812
Izod Impact, notched, 23°C	290	J/m	ASTM D 256
Multiaxial Impact	2	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	19	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m <sup>2</sup>	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	102	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	95	°C	ASTM D 648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	102	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	97	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Density	1.26	g/cm <sup>3</sup>	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.11	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.4 - 0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.5 - 0.8	%	ASTM D 955
Density	1.26	g/cm <sup>3</sup>	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.11	%	ISO 62

Source GMD, last updated:04/23/2008

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:04/23/2008

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.

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