LNP™ COLORCOMP™ COMPOUND AX03575

PDX-A-03575

DESCRIPTION

LNP COLORCOMP AX03575 is a compound based on Acrylonitrile Butadiene Styrene (ABS). Added features of this grade include low gloss and high flow.

GENERAL INFORMATION	
Features	Good Processability, No PFAS intentionally added
Fillers	Unreinforced
Polymer Types	Acrylonitrile Butadiene Styrene (ABS)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Automotive	Automotive Interiors
Industrial	Industrial General

TYPICAL PROPERTY VALUES

Revision 20240220

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Modulus, 50 mm/min	2210	MPa	ASTM D638
Tensile Stress, yld, Type I, 50 mm/min	36.5	MPa	ASTM D638
Flexural Stress	72	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2410	MPa	ASTM D790
Hardness, Rockwell R	105	-	ASTM D785
Tensile Stress, yield, 50 mm/min	39	MPa	ISO 527
Flexural Modulus, 2 mm/min	2430	MPa	ISO 178
IMPACT [1]			
Izod Impact, notched, 23°C	170	J/m	ASTM D256
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	90	°C	ASTM D648
HDT, 0.45 MPa, 3.2 mm	100	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	76	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, annealed	95	°C	ASTM D648
CTE, -40°C to 40°C, flow	9.0E-5	1/°C	ASTM E831
Vicat Softening Temp, Rate A/120	107	°C	ASTM D1525
Vicat Softening Temp, Rate B/50	96	°C	ISO 306
PHYSICAL [1]			
Specific Gravity	1.05	-	ASTM D792
Melt Flow Rate, 230°C/3.8 kg	7	g/10 min	ASTM D1238
Melt Flow Rate, 220°C/10.0 kgf	21	g/10 min	ASTM D1238
INJECTION MOLDING [2]			

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Temperature	80 – 95	°C	
Drying Time	2 – 4	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.1	%	
Melt Temperature	220 – 260	°C	
Nozzle Temperature	220 – 260	°C	
Front - Zone 3 Temperature	215 – 240	°C	
Middle - Zone 2 Temperature	205 – 225	°C	
Rear - Zone 1 Temperature	190 – 210	°C	
Mold Temperature	50 – 70	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	30 – 60	rpm	
Shot to Cylinder Size	50 – 70	%	
Vent Depth	0.035 – 0.051	mm	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

DISCLAIMER