



## LNP™ STAT-KON™ Compound AX02747

### Americas: COMMERCIAL

Also known as: LNP™ STAT-KON™ Compound PDX-A-02747

Product reorder name: AX02747

LNP STAT-KON AX02747 is a compound based on ABS resin containing Proprietary Filler(s). Added feature of this material is: Electrically Conductive.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, brk, Type I, 5 mm/min	1450	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	0.9	%	ASTM D 638
Tensile Modulus, 50 mm/min	306500	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	2030	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	241600	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, break, 5 mm/min	141	MPa	ISO 527
Tensile Strain, break, 5 mm/min	0.9	%	ISO 527
Tensile Modulus, 1 mm/min	25300	MPa	ISO 527
Flexural Stress	215	MPa	ISO 178
Flexural Modulus, 2 mm/min	24670	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	32	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
Multiaxial Impact	27	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	61	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80°10°4 +23°C	18	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80°10°4 +23°C	5	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL</b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	106	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	101	°C	ASTM D 648
CTE, -30°C to 30°C, flow	2.1E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	2.5E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80°10°4 sp=64mm	107	°C	ISO 75/Bf

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(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.  
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>THERMAL</b>			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	101	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.27	-	ASTM D 792
Density	1.27	g/cm <sup>3</sup>	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.17	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.1 - 0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.3 - 0.5	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.24	%	ISO 62
<b>ELECTRICAL</b>			
Surface Resistivity	2.E+00 - 6.E+00	Ohm	ASTM D 257

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
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

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