



## LNP™ THERMOCOMP™ Compound AF004AHP

### Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound AF-1004 HC

Product reorder name: AF004AHP

LNP\* THERMOCOMP\* AF004AHP is a compound based on ABS resin containing 20% Glass Fiber. Added feature of this grade is: Healthcare.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, brk, Type I, 5 mm/min	700	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.7	%	ASTM D 638
Tensile Modulus, 5 mm/min	63700	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1020	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	990	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	59700	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, break, 5 mm/min	66	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.6	%	ISO 527
Tensile Modulus, 1 mm/min	5950	MPa	ISO 527
Flexural Stress	98	MPa	ISO 178
Flexural Modulus, 2 mm/min	5520	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	26	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
Multiaxial Impact	25	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	111	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	17	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	103	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	99	°C	ASTM D 648
CTE, -30°C to 30°C, flow	4.2E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	8.6E-05	1/°C	ASTM D 696

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



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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>THERMAL</b>			
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	104	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	99	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.23	-	ASTM D 792
Density	1.23	g/cm <sup>3</sup>	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.16	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.55	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.26	%	ISO 62

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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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