



LNP™ THERMOCOMP™ Compound AF004

Americas: COMMERCIAL

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

Product reorder name: AF004

LNP THERMOCOMP AF004 is a compound based on ABS resin containing 20% Glass Fiber.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	800	kgf/cm ²	ASTM D 638
Tensile Strain, break	2.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	62900	kgf/cm ²	ASTM D 638
Flexural Stress	1320	kgf/cm ²	ASTM D 790
Flexural Modulus	62700	kgf/cm ²	ASTM D 790
Tensile Stress, break	81	MPa	ISO 527
Tensile Strain, break	2	%	ISO 527
Tensile Modulus, 1 mm/min	6000	MPa	ISO 527
Flexural Stress	123	MPa	ISO 178
Flexural Modulus	5860	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	40	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	8	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	112	cm-kgf	ASTM D 3763
Multiaxial Impact	31	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	23	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	103	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	93	°C	ISO 75/Af
PHYSICAL			
Density	1.198	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.24	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.2	%	ASTM D 955



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PHYSICAL			
Mold Shrinkage, xflow, 24 hrs (5)	0.4	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.24	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.4	%	ISO 294
Density	1.19	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.39	%	ISO 62
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL 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