

LNP* Colorcomp* Compound AX03654

Americas: COMMERCIAL

Also known as: PDX-A-03654
Product Reorder Name: AX03654

LNP COLORCOMP* AX03654 is a compound based on Acrylonitrile Butadiene Styrene resin containing Flame Retardant, Unfilled Custom Color. Added features of this material include: Flame Retardant.

Property

| TYPICAL PROPERTIES ⁽¹⁾ | | | |
|---------------------------------------|-----------|-------------------|-------------|
| MECHANICAL | Value | Unit | Standard |
| Tensile Stress, yield | 39 | MPa | ASTM D 638 |
| Tensile Stress, break | 30 | MPa | ASTM D 638 |
| Tensile Strain, yield | 2.1 | % | ASTM D 638 |
| Tensile Strain, break | 13.6 | % | ASTM D 638 |
| Tensile Modulus, 50 mm/min | 2440 | MPa | ASTM D 638 |
| Flexural Stress | 65 | MPa | ASTM D 790 |
| Flexural Modulus | 2390 | MPa | ASTM D 790 |
| Tensile Stress, yield | 38 | MPa | ISO 527 |
| Tensile Stress, break | 31 | MPa | ISO 527 |
| Tensile Strain, yield | 2 | % | ISO 527 |
| Tensile Strain, break | 15.3 | % | ISO 527 |
| Tensile Modulus, 1 mm/min | 2390 | MPa | ISO 527 |
| Flexural Stress | 65 | MPa | ISO 178 |
| Flexural Modulus | 2310 | MPa | ISO 178 |
| IMPACT | Value | Unit | Standard |
| Izod Impact, unnotched, 23°C | 1068 | J/m | ASTM D 4812 |
| Izod Impact, notched, 23°C | 170 | J/m | ASTM D 256 |
| Izod Impact, unnotched 80*10*4 +23°C | 39 | kJ/m ² | ISO 180/1U |
| Izod Impact, notched 80*10*4 +23°C | 11 | kJ/m ² | ISO 180/1A |
| THERMAL | Value | Unit | Standard |
| HDT, 1.82 MPa, 3.2mm, unannealed | 72 | °C | ASTM D 648 |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm | 72 | °C | ISO 75/Af |
| PHYSICAL | Value | Unit | Standard |
| Density | 1.16 | g/cm ³ | ASTM D 792 |
| Mold Shrinkage, flow, 24 hrs | 0.5 - 0.7 | % | ASTM D 955 |
| Mold Shrinkage, xflow, 24 hrs | 0.5 - 0.7 | % | ASTM D 955 |
| Mold Shrinkage, flow, 24 hrs | 0.5 - 0.7 | % | ISO 294 |
| Mold Shrinkage, xflow, 24 hrs | 0.5 - 0.7 | % | ISO 294 |
| Density | 1.16 | g/cm ³ | ISO 1183 |

Source GMD, last updated:10/05/2004

Processing

| Parameter | Value | Unit |
|--------------------|---------|------|
| Injection Molding | | |
| Drying Temperature | 70 - 80 | °C |
| Drying Time | 4 | hrs |

| | | |
|-----------------------------|------------|-----|
| Maximum Moisture Content | 0.05 - 0.1 | % |
| Melt Temperature | 200 - 210 | °C |
| Front - Zone 3 Temperature | 205 - 215 | °C |
| Middle - Zone 2 Temperature | 195 - 205 | °C |
| Rear - Zone 1 Temperature | 180 - 195 | °C |
| Mold Temperature | 10 - 50 | °C |
| Back Pressure | 0.2 - 0.3 | MPa |
| Screw Speed | 30 - 60 | rpm |

Source GMD, last updated:10/05/2004

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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