LNP™ THERMOTUF™ COMPOUND VX99809

PDX-V-99809

DESCRIPTION

LNP THERMOTUF VX99809 is a compound based on Super Tough Nylon resin containing Proprietary Filler(s). Added faeture of this material is: High Impact.

TYPICAL PROPERTY VALUES

Revision 20191216

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	43	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	40	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3.9	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	75.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	1980	MPa	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span	1220	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	42	MPa	ISO 527
Tensile Stress, break, 5 mm/min	41	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.6	%	ISO 527
Tensile Strain, break, 5 mm/min	129	%	ISO 527
Tensile Modulus, 1 mm/min	1880	MPa	ISO 527
Flexural Modulus, 2 mm/min	1300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1330	J/m	ASTM D 4812
Izod Impact, notched, 23°C	885	J/m	ASTM D 256
Multiaxial Impact	49	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	145	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	82	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	178	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	49	°C	ASTM D 648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	100	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	47	°C	ISO 75/Af
PHYSICAL			
Density	1.084	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.92	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	2 – 3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	2 – 3	%	ASTM D 955
Density	1.08	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	1.9	%	ISO 62
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15	%	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Temperature	280 – 295	°C	
Front - Zone 3 Temperature	295 – 305	°C	
Middle - Zone 2 Temperature	275 – 290	°C	
Rear - Zone 1 Temperature	260 – 270	°C	
Mold Temperature	95 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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