LNP™ THERMOCOMP™ COMPOUND PX87791

PDX-P-87791

DESCRIPTION

LNP THERMOCOMP PX87791 is a compound based on Nylon 6 resin containing Proprietary Filler(s).

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	163	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	240	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	99420	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	774	J/m	ASTM D 4812
Izod Impact, notched, 23°C	112	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	213	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.46	-	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.9	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2 – 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.6 – 0.8	%	ASTM D 955
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	265 – 275	°C	
Front - Zone 3 Temperature	275 – 290	°C	
Middle - Zone 2 Temperature	265 – 275	°C	
Rear - Zone 1 Temperature	250 – 260	°C	
Mold Temperature	80 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	30 – 60	rpm	

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