LNP™ VERTON™ COMPOUND PX06419

PDX-P-00783 HS

DESCRIPTION

LNP VERTON PX06419 is a compound based on Polyamide 6 (Nylon 6) resin containing 50% long glass fiber and proprietary fillers. Added features include Heat Stabilized and Structural.

GENERAL INFORMATION	
Features	Heat Stabilized, High stiffness/Strength, No PFAS intentionally added
Fillers	Glass Fiber, Proprietary Filler
Polymer Types	Polyamide 6 (Nylon 6)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Automotive	Automotive Exteriors
Building and Construction	Building Component
Consumer	Sport/Leisure, Home Appliances, Commercial Appliance
Industrial	Industrial General

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, break	228	MPa	ASTM D638
Tensile Strain, break	2.2	%	ASTM D638
Tensile Modulus, 50 mm/min	17440	MPa	ASTM D638
Flexural Stress	296	MPa	ASTM D790
Flexural Modulus	15230	MPa	ASTM D790
IMPACT [1]			
Izod Impact, unnotched, 23°C	1602	J/m	ASTM D4812
Izod Impact, notched, 23°C	357	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	205	°C	ASTM D648
PHYSICAL [1]			
Density	1.61	g/cm³	ASTM D792
Mold Shrinkage, flow, 24 hrs [2]	0.2	%	ASTM D955
INJECTION MOLDING [3]			
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	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Rear - Zone 1 Temperature	250 – 260	°C	
Mold Temperature	80 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	30 – 60	rpm	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) 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.

(3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

DISCLAIMER