LNP™ COLORCOMP™ COMPOUND PX99848

PDX-P-99848

DESCRIPTION

LNP COLORCOMP PX99848 compound is based on Nylon 6 resin. Added features of this grade include: Heat Stabilized.

GENERAL INFORMATION	
Features	Heat Stabilized, Aesthetics/Visual effects, No PFAS intentionally added
Fillers	Unreinforced
Polymer Types	Polyamide 6 (Nylon 6)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Automotive	Automotive Interiors
Consumer	Home Decoration, Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance
Electrical and Electronics	Mobile Phone - Computer - Tablets

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yield	76	MPa	ASTM D638
Tensile Stress, break	76	MPa	ASTM D638
Tensile Strain, yield	3.5	%	ASTM D638
Tensile Strain, break	4.5	%	ASTM D638
Tensile Modulus, 50 mm/min	3460	MPa	ASTM D638
Flexural Stress	103	MPa	ASTM D790
Flexural Modulus	2880	MPa	ASTM D790
IMPACT [1]			
Izod Impact, unnotched, 23°C	640	J/m	ASTM D4812
Izod Impact, notched, 23°C	58	J/m	ASTM D256
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	180	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	57	°C	ASTM D648
PHYSICAL [1]			
Density	1.14	g/cm³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	1.3	%	ASTM D570
Mold Shrinkage, flow, 24 hrs [2]	1.2 – 1.4	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs [2]	1.2 – 1.4	%	ASTM D955
INJECTION MOLDING [3]			
Drying Temperature	80	°C	
Drying Time	4	Hrs	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	

(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