LNP™ VERTON™ COMPOUND PX06418

PDX-P-00700 HS

DESCRIPTION

LNP VERTON PX06418 is a compound based on Polyamide 6 (Nylon 6) resin containing 35% long glass fiber and proprietary fillers. Added features of this grade are 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, brk, Type I, 5 mm/min	203	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D638
Tensile Modulus, 5 mm/min	11960	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	309	MPa	ASTM D790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	307	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	10000	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	193	MPa	ISO 527
Tensile Stress, break, 5 mm/min	182	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.6	%	ISO 527
Tensile Modulus, 1 mm/min	10900	MPa	ISO 527
Flexural Strength, 2 mm/min	290	MPa	ISO 178
Flexural Modulus, 2 mm/min	9530	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched, 23°C	1040	J/m	ASTM D4812
Izod Impact, notched, 23°C	284	J/m	ASTM D256
Multiaxial Impact	5	J	ISO 6603
Instrumented Dart Impact Total Energy, 23°C	15	J	ASTM D3763
Izod Impact, unnotched 80*10*4 +23°C	64	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	27	kJ/m²	ISO 180/1A
THERMAL [1]			

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT, 0.45 MPa, 3.2 mm, unannealed	213	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	208	°C	ASTM D648
CTE, -30°C to 30°C, flow	4.8E-05	1/°C	ASTM D696
CTE, -30°C to 30°C, xflow	1.1E-04	1/°C	ASTM D696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	213	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	207	°C	ISO 75/Af
PHYSICAL (1)			
Specific Gravity	1.41	-	ASTM D792
Density	1.4	g/cm³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	1.1	%	ASTM D570
Mold Shrinkage, flow, 24 hrs (2)	0.1 – 0.3	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs (2)	0.4 – 0.6	%	ASTM D955
Moisture Absorption (23°C / 50% RH)	1.7	%	ISO 62
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	
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