

LNP™ THERMOTUF™ VX99810 compound

Polyamide

SABIC Innovative Plastics

Message:

LNP THERMOTUF VX99810 is a compound based on Super Tough Nylon resin containing Proprietary Filler(s). Added feature of this material is: High Impact.

Also known as: LNP* THERMOTUF* Compound PDX-V-99810

Product reorder name: VX99810

General Information			
Filler / Reinforcement	Proprietary		
Features	High Impact Resistance		
	Ultra High Toughness		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.18	g/cm ³	ASTM D792
--	1.17	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.70 to 0.90	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	1.2	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.9	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4660	MPa	ASTM D638
--	4420	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	74.4	MPa	ASTM D638
Yield	73.0	MPa	ISO 527-2/5
Break ³	69.7	MPa	ASTM D638
Break	70.5	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.7	%	ASTM D638
Yield	2.6	%	ISO 527-2/5
Break ⁵	4.5	%	ASTM D638
Break	3.2	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	3090	MPa	ASTM D790

-- ⁷	3240	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	140	J/m	ASTM D256
23°C ⁸	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	710	J/m	ASTM D4812
23°C ⁹	46	kJ/m ²	ISO 180/1U
Multi-Axial Instrumented Impact Energy	7.80	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	238	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	230	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	204	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	184	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15	%	
Rear Temperature	260 to 271	°C	
Middle Temperature	277 to 288	°C	
Front Temperature	293 to 304	°C	
Processing (Melt) Temp	282 to 293	°C	
Mold Temperature	93.3 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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