

LNP™ VERTON™ RX10409D compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP VERTON RX10409D is a compound based on Nylon 66 containing proprietary fillers. Added feature of this grade is: Structural.

Also known as: LNP* VERTON* Compound RX10409D

Product reorder name: RX10409D

General Information			
Filler / Reinforcement	Proprietary		
Uses	Structural Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.40	%	
Across Flow : 24 hr	0.80	%	
Water Absorption			
24 hr, 50% RH	0.66	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	12000	MPa	ASTM D638
--	11800	MPa	ISO 527-2/1
Tensile Strength			
Break ²	203	MPa	ASTM D638
Break	199	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.4	%	ASTM D638
Break	2.3	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	11100	MPa	ASTM D790
-- ⁵	10300	MPa	ISO 178
Flexural Stress			
--	285	MPa	ISO 178
Yield, 50.0 mm Span ⁶	305	MPa	ASTM D790
Break, 50.0 mm Span ⁷	302	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	22	kJ/m ²	ISO 179/2C
Charpy Unnotched Impact Strength (23°C)	88	kJ/m ²	ISO 179/2U
Notched Izod Impact			

23°C	270	J/m	ASTM D256
23°C ⁸	24	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1200	J/m	ASTM D4812
23°C ⁹	76	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	22.0	J	ASTM D3763
--	7.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	258	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	258	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	253	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	253	°C	ISO 75-2/Af
CLTE			ASTM E831
Flow : -40 to 40°C	2.2E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.4E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 to 0.25	%	
Rear Temperature	282 to 293	°C	
Middle Temperature	288 to 299	°C	
Front Temperature	288 to 299	°C	
Processing (Melt) Temp	288 to 304	°C	
Mold Temperature	93.3 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	1.3 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

