

LNP THERMOCOMP PX85100 compound

Polyamide 6
SABIC Innovative Plastics

Message:

LNP THERMOCOMP PX85100 is a compound based on Nylon 6 resin containing Proprietary Filler(s).
Also known as: LNP* THERMOCOMP* Compound PDX-P-85100
Product reorder name: PX85100

General Information			
Filler / Reinforcement	Proprietary		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39	g/cm ³	ASTM D792
Molding Shrinkage - Flow (24 hr)	0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	10300	MPa	ASTM D638
Tensile Strength			ASTM D638
Break	157	MPa	
Break ²	157	MPa	
Tensile Elongation			ASTM D638
Yield ³	9.0	%	
Break	2.7	%	
Break ⁴	2.7	%	
Flexural Modulus			ASTM D790
--	8030	MPa	
50.0 mm Span ⁵	8030	MPa	
Flexural Strength	228	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	80	J/m	ASTM D256
Unnotched Izod Impact (23°C)	1100	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	206	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 to 0.25	%	
Rear Temperature	249 to 260	°C	
Middle Temperature	266 to 277	°C	
Front Temperature	277 to 288	°C	
Processing (Melt) Temp	266 to 277	°C	

Mold Temperature	82.2 to 93.3	°C
Back Pressure	0.344 to 0.689	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.	1.3 mm/min	

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