

Developmental Product Information

High Performance Nylon HPNMG35.XN1359

HPNMG35.XN1359 is a high melting polyamide blend reinforced with 35 % by weight of a combination of glass fiber and mineral . The product is internally lubricated for mold release and also has an effective heat stabilizer incorporated into the formulation to aid in retention of properties on exposure to elevated temperatures.

This compound combines high strength and rigidity, with an ability to withstand high end use temperatures. It also exhibits good control of warpage during the molding of large or complex shaped parts.

PRELIMINARY PROPERTIES DRY AS MOLDED

<u>PROPERTY</u>	<u>ASTM TEST METHOD</u>	<u>ENGLISH</u>		<u>S.I.</u>	
		<u>UNITS</u>	<u>VALUE</u>	<u>UNITS</u>	<u>VALUE</u>
Melting Range	D789	°F	535-575	°C	280 -300
Specific Gravity	D792	-	1.47	-	1.47
Heat Deflection Temperature at 264 lbs/in ² (1.82MPa)	D648	°F	535	°C	280
Mold Shrinkage Guideline* (Flow Direction)	1/8" section	%	0.2-0.3	%	0.2-0.3
Tensile Strength at Break	D638	lbs/in ²	21,000	MPa	145
Elongation at Break	D638	%	1 -2	%	1 -2
Flexural Strength	D790	lbs/in ²	30,000	MPa	207
Flexural Modulus	D790	lbs/in ²	1,200,000	MPa	8276
Izod Impact Strength (Notched, 1/8" specimen)	D256	ft. lbs/in of notch	0.7	J/m	37

***Please review shrinkage projections for specific applications with an MDE Technical Representative.**

All data generated using test specimens injection molded from natural color material. Inclusion of other additives may change some or all of these test results. Test specimens are stored in a moisture proof container immediately after molding and contain less than 0.2% moisture; tests are conducted at 23°C and 50% relative humidity unless otherwise stated.

These mechanical property test data have been developed using injection molded specimens tested under standardized conditions; furthermore, many of the mechanical properties of thermoplastic materials can be influenced by changes in processing conditions, environmental factors such as temperature and humidity, and rate of application of stress. Therefore, these test results, which characterize typical production material, should not be used either to establish specification limits or alone as the basis for engineering design.

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Processing Guidelines

Drying

Nylon compounds from MDE are shipped in moisture resistant packaging, dried to less than 0.25% moisture. Most processors will further dry nylon resins and compounds, especially after exposure of virgin resin to ambient air for more than an hour, or when a proportion of reground material is being used.

The use of dehumidifying dryers is strongly preferred. The dew point of the drying air stream should be no more than -20°F, and preferably lower. The drying air temperature must be high enough to achieve a pellet temperature of 175-180°F. If using a hopper drier, depending on air hose length and insulation of hoses and hopper, the drying air temperature may need to reach 200-220°F to achieve the required material temperature.

If the pellet temperature reaches 180°F, a residence time of 4 hours is generally adequate to ensure that the material is ready to be processed. Only if residence times are limited to 2 hours should a pellet temperature of 200°F be considered; at 200°F, there is a risk of material oxidation, with associated yellowing of natural color and loss of part performance.

Nylon compounds usually demonstrate visual evidence of unacceptably high moisture levels. This includes splay or silver streaking on the molded part surface, or an unstable melt or nozzle drool at the machine. Additional drying time is indicated if these characteristics are observed.

If moisture analysis equipment is available, an acceptable moisture content range for normal processing is 0.1% to 0.25% maximum. Mold-in-color parts with critical cosmetic requirements may require drying to < 0.1%.

Temperature Guidelines

The following temperature guidelines are suggested for general use **if a machine can be selected where shot size is 40-70% of nominal machine capacity.**

<u>Tool Surface Temperature (°F)</u>	<u>Melt Temperatures (°F)</u>			<u>Typical Cylinder Temperatures(°F)</u>		
	<u>Max.</u>	<u>Preferred</u>	<u>Min.</u>	<u>Front</u>	<u>Center</u>	<u>Rear</u>
270-320	640	600-625	580	600	600	600

- A "flat" temperature profile helps ensure a homogeneous melt, improves screw recovery and helps to optimize cycle times.
- Oil heaters will be required to maintain a mold surface temperature in the suggested range. These temperatures are necessary to help consistency of mold fill and therefore consistency of dimensions, minimize the effect of weld lines and are required to realize best molded part performance.
- A medium to fast injection speed maximizes weld line strength and minimizes molded-in stress. Good venting of cavities is essential to allow fast fill without burning.

Screw Forward Time

Adequate screw forward time under follow-up pressure is important to ensure proper packing before gate freeze, during which time it is essential to maintain a "cushion" of 1/8"-1/4". Optimum screw forward time can be judged by a part weight vs. forward time plot. Avoid overpacking, which can generate molded-in stresses.

Screw Recovery

It is recommended that back pressure be applied to the screw to help development of a homogenous melt, and to ensure consistent shot volume. For this reinforced grade, limiting back pressure to about 50 psi gauge will minimize the risk of mechanical damage to the glass fibers with consequent loss of part performance. Screw rotation should also be as slow as possible consistent with cycle time goals, usually 40-80 r.p.m.

Mold Shrinkage

Standard ASTM test specimens are used to develop shrinkage guidelines. Test specimens are end-gated, 1/8 inch thickness, and molded at conditions recommended for this formulation. **Actual shrinkage in molded parts will depend on several variables, including processing conditions, part configuration and gate location, both of which influence material flow direction, and wall section thickness.**

