



## InLube® PA612GF30TF13SI2

**PRODUCT DESCRIPTION** 30% GLASS FIBER REINFORCED, 13% PTFE/2% SILICONE LUBRICATED NYLON 6/12

**MATERIAL STATUS** Commercial: Active

**AVAILABILITY** Africa & Middle East, Asia Pacific, Europe, Latin America, North America

**FILLER / REINFORCEMENT** Glass Fiber, 30% Filler by Weight

**ADDITIVE** PTFE Lubricant: 13%, Silicone Lubricant: 2%

**FEATURES** Chemical Resistant, Filled, Good Dimensional Stability, Good Mold Release, High Stiffness, High Strength, Low Friction, Lubricated, Wear Resistant

**USES** Closures, Consumer Applications, Electrical/Electronic Applications, Engineering Parts, Household Goods, Industrial Applications, Industrial Parts, Office Automation Equipment, Outdoor Applications

**FORMS** Pellets

**PROCESSING METHOD** Injection Molding

PHYSICAL	NOMINAL VALUE	UNIT	TEST METHOD
Density / Specific Gravity	1.42	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20 to 0.60	%	
Water Absorption			ASTM D570
24 hr	0.10	%	
Saturation	1.5	%	
MECHANICAL	NOMINAL VALUE	UNIT	TEST METHOD
Tensile Strength (Break)	134	MPa	ASTM D638
Tensile Elongation (Break)	2.0 to 4.0	%	ASTM D638
Flexural Modulus	7580	MPa	ASTM D790
Flexural Strength	203	MPa	ASTM D790
IMPACT	NOMINAL VALUE	UNIT	TEST METHOD
Notched Izod Impact	120	J/m	ASTM D256
Unnotched Izod Impact	800 to 910	J/m	ASTM D4812
THERMAL	NOMINAL VALUE	UNIT	TEST METHOD
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed	216	°C	
ELECTRICAL	NOMINAL VALUE	UNIT	TEST METHOD
Surface Resistivity	1.0E+2 to 1.0E+6	ohms	ASTM D257



<b>INJECTION</b>	<b>NOMINAL VALUE</b>	<b>UNIT</b>
Drying Temperature	79	°C
Drying Time	4.0	hr
Processing (Melt) Temp	266 to 277	°C
Mold Temperature	93	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.013 to 0.025	mm

**NOTES**

<sup>1</sup> Typical properties: these are not to be construed as specifications.

