

InLube® PA6TF20FRHS

Americhem - Polyamide 6

General Information

Product Description

20% PTFE LUBRICATED FLAME RETARDANT HEAT STABILIZED NYLON 6

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Flame Retardant	• Heat Stabilizer	• PTFE Lubricant: 20%
Features	• Chemical Resistant • Flame Retardant • Good Mold Release	• Halogenated • Heat Stabilized • 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 • Window & Door Components
Forms	• Pellets		
Processing Method	• Injection Molding		

 Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.43		ASTM D792
Molding Shrinkage - Flow	0.013 to 0.016	in/in	ASTM D955
Water Absorption (24 hr)	1.1	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	7500	psi	ASTM D638
Tensile Elongation (Yield)	4.0 to 6.0	%	ASTM D638
Flexural Modulus	400000	psi	ASTM D790
Flexural Strength (Yield)	12500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft-lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	12	ft-lb/in	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	150	°F	ASTM D648
CLTE - Flow	4.7E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+17	ohms	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Drying Time	4.0	hr
Processing (Melt) Temp	480 to 550	°F
Mold Temperature	200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm
Vent Depth	5.0E-4 to 1.0E-3	in

