

**InLube® PA6GF30TF15**

Americhem - Polyamide 6

## General Information

**Product Description**

30% GLASS FIBER REINFORCED, 15% PTFE LUBRICATED NYLON 6

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Additive	• PTFE Lubricant: 15%		
Features	• Chemical Resistant	• Good Mold Release	• Low Friction
	• Filled	• High Stiffness	• Lubricated
	• Good Dimensional Stability	• High Strength	• Wear Resistant
Uses	• Closures	• Household Goods	• Outdoor Applications
	• Consumer Applications	• Industrial Applications	• Window & Door Components
	• Electrical/Electronic Applications	• Industrial Parts	
	• Engineering Parts	• Office Automation Equipment	
Forms	• Pellets		
Processing Method	• Injection Molding		

 Properties <sup>1</sup>

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.49		ASTM D792
Specific Volume	18.6	in <sup>3</sup> /lb	
Molding Shrinkage - Flow	3.0E-3 to 4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.50	%	ASTM D570
<b>Mechanical</b>			
	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Strength	19000	psi	ASTM D638
Tensile Elongation (Yield)	2.0 to 4.0	%	ASTM D638
Flexural Modulus	1.20E+6	psi	ASTM D790
Shear Strength	11000	psi	ASTM D732
<b>Impact</b>			
	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	1.9	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	20	ft·lb/in	ASTM D4812
<b>Thermal</b>			
	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648
CLTE - Flow	2.3E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Surface Resistivity	1.0E+17	ohms	
<b>Flammability</b>			
	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.06 in)	HB		UL 94

## Processing Information

	Nominal Value	Unit
<b>Injection</b>		
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

