

InLube® PA6TF20

Americhem - Polyamide 6

General Information
Product Description

20% PTFE LUBRICATED NYLON 6

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Asia Pacific • Europe • Latin America • North America
Additive	• PTFE Lubricant: 20%
Features	• Chemical Resistant • Good Mold Release • 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	1.26		ASTM D792
Specific Volume	22.0	in ³ /lb	
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	8500	psi	ASTM D638
Tensile Elongation (Yield)	8.0 to 10	%	ASTM D638
Flexural Modulus	300000	psi	ASTM D790
Shear Strength	9000	psi	ASTM D732
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)	15	ft·lb/in	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	160	°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)	HB		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

