

Plaslube® PA6 GF13 TX5 OR033

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight
Additive	• Lubricant • PTFE Lubricant
Features	• Lubricated
Appearance	• Orange
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	13800	psi	ASTM D638
Tensile Elongation (Break)	3.3	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.86	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	200	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	460 to 500	°F
Middle Temperature	460 to 500	°F
Front Temperature	460 to 500	°F
Nozzle Temperature	460 to 520	°F
Processing (Melt) Temp	480 to 540	°F
Mold Temperature	160 to 200	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 75.0	psi
Screw Speed	Slow-Moderate	

Notes
¹ Typical properties: these are not to be construed as specifications.
