

**Plaslube® J-1/30/TF/15**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
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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	• Lubricated
Uses	• Bearings • Gears • Cams • Pulleys
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.52		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Strength	23000	psi	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus (73°F)	1.35E+6	psi	ASTM D790
Flexural Strength	34500	psi	ASTM D790
Flexural Strength (Break, 73°F)	34500	psi	ASTM D790
Compressive Strength (73°F)	28000	psi	ASTM D695
Shear Strength	10000	psi	ASTM D732
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.25		
vs. Steel - Static	0.20		
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (73°F, 0.125 in)	2.5	ft·lb/in	ASTM D256
<b>Hardness</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Rockwell Hardness (R-Scale)	119		ASTM D785
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (66 psi, Unannealed)	500	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	490	°F	ASTM D648
CLTE - Flow	2.4E-5	in/in/°F	ASTM D696
RTI Elec (0.06 in)	149	°F	UL 746B
RTI Imp (0.06 in)	149	°F	UL 746B
RTI Str (0.06 in)	149	°F	UL 746B
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.06 in)	HB		UL 94
<b>Additional Information</b>			
Coefficient of Friction, Static, Thrust washer, 40psi, ambient temp.: 0.20			
Coefficient of Friction, Dynamic, Thrust washer, 40psi, 50 ft/min, ambient temp.: 0.25			
Limiting PV, Thrust washer, 100 FPM, ambient temperature: 2E4			

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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Drying Temperature	180 °F
Drying Time	2.0 to 4.0 hr
Suggested Max Moisture	0.12 %
Rear Temperature	540 to 560 °F
Middle Temperature	550 to 570 °F
Front Temperature	530 to 550 °F
Nozzle Temperature	540 to 560 °F
Processing (Melt) Temp	540 to 580 °F
Mold Temperature	130 to 200 °F
Injection Rate	Moderate-Fast
Back Pressure	50.0 to 100 psi

#### Injection Notes

Screw Speed: Medium

Recommendations for Molding and Tool Conditions: Well vented

Moisture Content, as received: Product is packaged at 0.2% or less.

Recommended Max Moisture: 0.12% down to 0.08%

#### Notes

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

