

Plaslube® J-1/30/TF/13/SI/2

Techmer Polymer Modifiers - Polyamide 66

General Information

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: 13%	• Silicone Lubricant: 2%	
Features	• Lubricated		
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.49		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.50	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (73°F)	23500	psi	ASTM D638
Tensile Elongation (Break, 73°F)	2.5	%	ASTM D638
Flexural Modulus (73°F)	1.37E+6	psi	ASTM D790
Flexural Strength (73°F)	35000	psi	ASTM D790
Compressive Strength (73°F)	24000	psi	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.8	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	490	°F	ASTM D648
CLTE - Flow	2.4E-5	in/in/°F	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
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%

