

Plaslube® PA6/6 AF10 HS L

Techmer Polymer Modifiers - *Polyamide 66*

General Information

General		
Material Status	• Commercial: Active	
Availability	• North America	
Filler / Reinforcement	• Aramid Fiber, 10% Filler by Weight	
Additive	• Heat Stabilizer	• PTFE Lubricant: 10%
Features	• Heat Stabilized	• Lubricated
	• Low Friction	• Wear Resistant
Appearance	• Colors Available	
Forms	• Pellets	
Processing Method	• Injection Molding	

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.17		ASTM D792
Molding Shrinkage - Flow (0.125 in)	8.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.85	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	13300	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	510000	psi	ASTM D790
Flexural Strength	20000	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.26		
vs. Steel - Static	0.21		
Wear Factor	60	10 ⁻⁴ -10 in ³ ·min/ft·lb·hr	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.80	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	450	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	350	°F	ASTM D648
Melting Temperature	491	°F	
CLTE - Flow	3.7E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	450	V/mil	ASTM D149

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 580	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	175 to 220	°F
Injection Rate	Slow-Moderate	



Back Pressure	0.00 to 50.0 psi
Injection Notes	
Screw Speed: Slow	
Recommendations for Molding and Tool Conditions: Well vented mold	
Moisture Content, as received: Product is packaged at 0.2% or less.	
Notes	

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

