

**Plaslube® PA6/6 CF30 TS12**

Techmer Polymer Modifiers - Polyamide 66

**General Information**
**General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 30% Filler by Weight
Additive	• PTFE + Silicone Lubricant: 12%
Features	• Lubricated                      • Wear Resistant
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		ASTM D792
Molding Shrinkage - Flow (0.125 in)	1.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.40	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	29000	psi	ASTM D638
Tensile Elongation (Break)	1.6	%	ASTM D638
Flexural Modulus	2.70E+6	psi	ASTM D790
Flexural Strength	44400	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.10		
vs. Steel - Static	0.090		
Wear Factor	8.0	10 <sup>-10</sup> in <sup>3</sup> ·min/ft·lb·hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.8	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	14	ft·lb/in	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	480	°F	ASTM D648
CLTE - Flow	1.5E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	10	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value	Unit	Test Method
Limiting Pressure Velocity	<ul style="list-style-type: none"> <li>• 30000.010 fpm psi-ft/min</li> <li>• 44000.0100 fpm</li> <li>• 22000.01000 fpm</li> </ul>		
TPCI #	6466101		

**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

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

