# Plaslube® PA6/6 CF10 TL15 BK

**Techmer Polymer Modifiers - *Polyamide 66***

## General Information

| General | |
|---|---|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Filler / Reinforcement | • Carbon Fiber |
| Additive | • PTFE + Silicone Lubricant: 15% |
| Features | • Lubricated • Wear Resistant |
| Appearance | • Black |
| Forms | • Pellets |
| Processing Method | • Injection Molding |

## Properties [1]

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 1.28 | | ASTM D792 |
| Molding Shrinkage - Flow (0.125 in) | 8.0E-3 | in/in | ASTM D955 |
| Water Absorption (24 hr) | 0.80 | % | ASTM D570 |
| **Mechanical** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Strength (Break) | 21000 | psi | ASTM D638 |
| Tensile Elongation (Break) | 4.0 | % | ASTM D638 |
| Flexural Modulus | 990000 | psi | ASTM D790 |
| Flexural Strength | 28800 | psi | ASTM D790 |
| Coefficient of Friction | | | ASTM D1894 |
| vs. Steel - Dynamic | 0.13 | | |
| vs. Steel - Static | 0.12 | | |
| Wear Factor | 12 | 10^-10 in³·min/ft·lb·hr | ASTM D3702 |
| **Impact** | **Nominal Value** | **Unit** | **Test Method** |
| Notched Izod Impact (73°F, 0.125 in) | 1.2 | ft·lb/in | ASTM D256 |
| **Hardness** | **Nominal Value** | **Unit** | **Test Method** |
| Rockwell Hardness (R-Scale) | 120 | | ASTM D785 |
| **Thermal** | **Nominal Value** | **Unit** | **Test Method** |
| Deflection Temperature Under Load (66 psi, Unannealed) | 490 | °F | ASTM D648 |
| Deflection Temperature Under Load (264 psi, Unannealed) | 485 | °F | ASTM D648 |

## 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.