

Plaslube® PA6/6 GF10 M/TL10

 Techmer Polymer Modifiers - *Polyamide 66*
General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Additive	• Molybdenum Disulfide Lubricant • PTFE Lubricant
Features	• Lubricated
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.27		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.75	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	11200	psi	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	510000	psi	ASTM D790
Flexural Strength	15000	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.26		
vs. Steel - Static	0.21		
Wear Factor	13	10 ⁻¹⁰ in ³ ·min/ft·lb·hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.0	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	450	°F	ASTM D648
CLTE - Flow	3.0E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	490	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94
Additional Information	Nominal Value	Unit	Test Method
Limiting Pressure Velocity	• 9500.010	fpm psi-ft/min	
	• 10000.0100	fpm	
	• 9500.01000	fpm	

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.

