# Plaslube® PA6/6 CF30 TL15 BK

**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 Lubricant: 15% | |
| Features | • Heat Stabilized<br>• Low Friction | • Lubricated<br>• Wear Resistant |
| Appearance | • Black | |
| Forms | • Pellets | |
| Processing Method | • Injection Molding | |

## Properties [1]

| Physical | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 1.38 | | ASTM D792 |
| Molding Shrinkage - Flow (0.125 in) | 3.0E-3 | in/in | ASTM D955 |
| Water Absorption (24 hr) | 0.48 | % | ASTM D570 |
| **Mechanical** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Strength (Break) | 28000 | psi | ASTM D638 |
| Tensile Elongation (Break) | 2.5 | % | ASTM D638 |
| Flexural Modulus | 1.98E+6 | psi | ASTM D790 |
| Flexural Strength | 41500 | psi | ASTM D790 |
| Coefficient of Friction | | | ASTM D1894 |
| vs. Steel - Dynamic | 0.10 | | |
| vs. Steel - Static | 0.090 | | |
| Wear Factor | 8.0 | 10^-10 in³·min/ft·lb·hr | |
| **Impact** | **Nominal Value** | **Unit** | **Test Method** |
| Notched Izod Impact (73°F, 0.125 in) | 2.0 | 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) | 498 | °F | ASTM D648 |
| Deflection Temperature Under Load (264 psi, Unannealed) | 488 | °F | ASTM D648 |
| CLTE - Flow | 1.0E-5 | in/in/°F | ASTM D696 |
| **Electrical** | **Nominal Value** | **Unit** | **Test Method** |
| Volume Resistivity | 10 to 1.0E+4 | ohms·cm | ASTM D257 |
| **Additional Information** | **Nominal Value** | **Unit** | **Test Method** |
| Limiting Pressure Velocity | • 30000.010 fpm<br>• 44000.0100 fpm<br>• 22000.01000 fpm | psi-ft/min | |
| TPCI # | 9441101 | | |

## 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.