

Plaslube® PA6/6 GF18 GL5 HS L BK

 Techmer Polymer Modifiers - *Polyamide 66*
General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 18% Filler by Weight
Additive	• Graphite Powder • Heat Stabilizer Lubricant
Features	• Heat Stabilized • Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.29		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.10E+6	psi	ASTM D638
Tensile Strength (Yield)	18000	psi	ASTM D638
Tensile Strength (Break)	17500	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.80	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	510 to 540	°F
Middle Temperature	520 to 550	°F
Front Temperature	530 to 560	°F
Nozzle Temperature	540 to 570	°F
Processing (Melt) Temp	515 to 565	°F
Mold Temperature	150 to 225	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

Notes

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

