

Plaslube® PA6/6 GF33 TL10 HS BK

Techmer Polymer Modifiers - Polyamide 66

General Information
General

| | |
|------------------------|---|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Filler / Reinforcement | • Glass Fiber, 33% Filler by Weight |
| Additive | • Heat Stabilizer • PTFE Lubricant: 10% |
| Features | • Heat Stabilized • Lubricated • Low Friction • Wear Resistant |
| Appearance | • Black |
| Forms | • Pellets |
| Processing Method | • Injection Molding |

Properties ¹

| | Nominal Value | Unit | Test Method |
|---|---------------|----------|-------------|
| Physical | | | |
| Density / Specific Gravity | 1.46 | | ASTM D792 |
| Molding Shrinkage - Flow (0.125 in) | 5.0E-3 | in/in | ASTM D955 |
| Water Absorption (24 hr) | 0.50 | % | ASTM D570 |
| Mechanical | | | |
| Tensile Strength (Yield) | 24600 | psi | ASTM D638 |
| Tensile Elongation (Break) | 2.0 | % | ASTM D638 |
| Flexural Modulus | 1.30E+6 | psi | ASTM D790 |
| Flexural Strength | 34500 | psi | ASTM D790 |
| Impact | | | |
| Notched Izod Impact (0.125 in) | 2.0 | ft-lb/in | ASTM D256 |
| Hardness | | | |
| Rockwell Hardness (R-Scale) | 90 | | ASTM D785 |
| Thermal | | | |
| Deflection Temperature Under Load (66 psi, Unannealed) | 485 | °F | ASTM D648 |
| Deflection Temperature Under Load (264 psi, Unannealed) | 460 | °F | ASTM D648 |
| CLTE - Flow | 1.0E-5 | in/in/°F | ASTM D696 |
| Electrical | | | |
| Volume Resistivity | 1.0E+15 | ohms·cm | ASTM D257 |
| Dielectric Strength (Method A (Short-Time)) | 550 | V/mil | ASTM D149 |
| Flammability | | | |
| Flame Rating (0.06 in) | HB | | UL 94 |

Processing Information

| | Nominal Value | Unit |
|------------------------|---------------|------|
| Injection | | |
| 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.

