

Plaslube® PA6/6 GF33 ML2

Techmer Polymer Modifiers - Polyamide 66

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Molybdenum Disulfide Lubricant: 2%
Features	• Lubricated
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.43		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.75	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	20000	psi	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	1.40E+6	psi	ASTM D790
Flexural Strength	38000	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.31		
vs. Steel - Static	0.24		
Wear Factor	75	10 ⁻¹⁰ in ³ ·min/ft·lb·hr	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.9	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	13	ft·lb/in	ASTM D4812
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	500	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	480	°F	ASTM D648
CLTE - Flow	3.8E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	500	V/mil	ASTM D149

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.

