

**InLube® PA610CF15TF15FRHS**

Americhem - Polyamide 610

**General Information**
**Product Description**

15% CARBON FIBER REINFORCED, 15% PTFE LUBRICATED, FLAME RETARDED AND HEAT STABILIZED NYLON 610

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Carbon Fiber, 15% Filler by Weight		
Additive	• Flame Retardant	• Heat Stabilizer	• PTFE Lubricant: 15%
Features	• Chemical Resistant • Filled • Flame Retardant • Good Dimensional Stability	• Good Mold Release • Halogenated • Heat Stabilized • High Stiffness	• High Strength • Low Friction • Lubricated • Wear Resistant
Uses	• Closures • Consumer Applications • Electrical/Electronic Applications	• Engineering Parts • Household Goods • Industrial Applications	• Industrial Parts • Office Automation Equipment • Outdoor Applications
Forms	• Pellets		
Processing Method	• Injection Molding		

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.45		ASTM D792
Molding Shrinkage - Flow	2.0E-3 to 4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	1.60E+6	psi	ASTM D638
Tensile Strength	17500	psi	ASTM D638
Tensile Elongation (Yield)	2.0 to 3.0	%	ASTM D638
Flexural Modulus	1.50E+6	psi	ASTM D790
Flexural Strength	23500	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	1.0	ft·lb/in	ASTM D256
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (264 psi, Unannealed)	400	°F	ASTM D648
<b>Electrical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Surface Resistivity	1.0E+4 to 1.0E+8	ohms	ASTM D257
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.06 in)	V-0		Internal Method

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	175	°F
Drying Time	4.0	hr
Processing (Melt) Temp	460 to 525	°F
Mold Temperature	200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

