

InLube® PA610GF30TF15FR

Americhem - Polyamide 610

General Information

Product Description			
30% GLASS FIBER REINFORCED, 15% PTFE LUBRICATED, FLAME RETARDED, NYLON 610			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Additive	• Flame Retardant	• PTFE Lubricant: 15%	
Features	• Chemical Resistant • Filled • Flame Retardant • Good Dimensional Stability	• Good Mold Release • Halogenated • 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 ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.66		ASTM D792
Molding Shrinkage - Flow	3.0E-3 to 4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.17	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.60E+6	psi	ASTM D638
Tensile Strength	17000	psi	ASTM D638
Tensile Elongation (Yield)	2.0 to 2.5	%	ASTM D638
Flexural Modulus	1.50E+6	psi	ASTM D790
Flexural Strength	23000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+17	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		V-0	
0.12 in		V-0	

Processing Information

	Nominal Value	Unit
Injection		
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

