

Plaslube® PA6/6 CF33 ML2 BK

Polyamide 66
Techmer Engineered Solutions

Message:

Plaslube® PA6/6 CF33 ML2 BK is a polyamide 66 (nylon 66) product, which contains a 10% carbon fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

- flame retardant/rated flame
- Wear-resistant
- Lubrication

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 10% filler by weight		
Additive	Molybdenum disulfide lubricant		
Features	Low friction coefficient		
	Good wear resistance		
	Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.29	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.10	%	ASTM D955
Water Absorption (24 hr)	0.48	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	193	MPa	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	17900	MPa	ASTM D790
Flexural Strength	303	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
With steel-dynamic	0.12		ASTM D1894
With steel-static	0.12		ASTM D1894
Wear Factor	40	10 ⁻⁸ mm ³ /N · m	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	260	°C	ASTM D648

1.8 MPa, not annealed	257	°C	ASTM D648
Melting Temperature	263	°C	
CLTE - Flow	1.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2 - 2.0E+2	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	282 - 293	°C	
Middle Temperature	288 - 299	°C	
Front Temperature	277 - 288	°C	
Nozzle Temperature	271 - 304	°C	
Processing (Melt) Temp	282 - 304	°C	
Mold Temperature	79.4 - 104	°C	
Injection Rate	Slow-Moderate		
Back Pressure	0.00 - 0.345	MPa	
Injection instructions			

Screw Speed: Slow Recommendations for Molding and Tool Conditions: Well vented mold Moisture Content, as received: Product is packaged at 0.2% or less.

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