

Plaslube® PA6/6 CF30 TL15 BK

Polyamide 66
Techmer Engineered Solutions

Message:

Plaslube®PA6/6 CF30 TL15 BK is a polyamide 66 (nylon 66) product, which contains a 30% carbon fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

Wear-resistant
Lubrication

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 30% filler by weight		
Additive	PTFE lubricant (15%)		
Features	Low friction coefficient		
	Good wear resistance		
	Thermal Stability		
	Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.48	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	193	MPa	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	13700	MPa	ASTM D790
Flexural Strength	286	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
With steel-dynamic	0.10		ASTM D1894
With steel-static	0.090		ASTM D1894
Wear Factor	16	10 ⁻⁸ mm ³ /N · m	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	259	°C	ASTM D648

1.8 MPa, not annealed	253	°C	ASTM D648
CLTE - Flow	1.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	10 - 1.0E+4	ohms·cm	ASTM D257
Additional Information	Nominal Value	Unit	

220001000 fpm

44000100 fpm

Limiting Pressure Velocity	3000010 fpm	psi-ft/min
TPCI #	9441101	

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: SlowRecommendations for Molding and Tool Conditions: Well vented moldMoisture Content, as received: Product is packaged at 0.2% or less.

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