

LubriOne™ NN-000/15T BK047

Polyamide 66

PolyOne Corporation

Message:

PTFE lubricated

| General Information | | | |
|------------------------------------------------------------------|-------------------|-------------------|-------------|
| Appearance | Black | | |
| Processing Method | Injection molding | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 1.22 | g/cm ³ | ASTM D792 |
| Molding Shrinkage - Flow | 1.5 - 2.0 | % | ASTM D955 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Strength ¹ | 70.0 | MPa | ASTM D638 |
| Tensile Elongation ² (Break) | 3.5 | % | ASTM D638 |
| Flexural Modulus ³ | 2300 | MPa | ASTM D790 |
| Flexural Strength ⁴ | 100 | MPa | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (23°C, 3.20 mm) | 40 | J/m | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm) | 65.0 | °C | ASTM D648 |
| Flammability | Nominal Value | | Test Method |
| Flame Rating (1.60 mm) | HB | | UL 94 |
| Injection | Nominal Value | Unit | |
| Drying Temperature | 80.0 - 90.0 | °C | |
| Drying Time | 4.0 - 6.0 | hr | |
| Rear Temperature | 260 - 280 | °C | |
| Middle Temperature | 260 - 280 | °C | |
| Front Temperature | 260 - 280 | °C | |
| Mold Temperature | 65.0 - 85.0 | °C | |

Injection instructions

Injection Pressure: MED-HIGH Hold Pressure: MED-HIGH Screw Speed: MODERATE Back Pressure: LOW

NOTE

| | |
|----|------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |

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