

Plaslube® PA6/6 GF15 ML3

Polyamide 66
Techmer Engineered Solutions

Message:

Plaslube® PA6/6 GF15 ML3 is a polyamide 66 (nylon 66) product, which contains a 15% glass fiber reinforced material. It can be processed by injection molding and is available in North America. The main characteristics are: lubrication.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	Molybdenum disulfide lubricant		
Features	Lubrication		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	1.8	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	110	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	4830	MPa	ASTM D790
Flexural Strength	165	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
With steel-dynamic	0.31		ASTM D1894
With steel-static	0.24		ASTM D1894
Wear Factor	150	10 ⁻⁸ mm ³ /N · m	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	255	°C	ASTM D648
1.8 MPa, not annealed	221	°C	ASTM D648
CLTE - Flow	3.2E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257

Dielectric Strength ¹	19	kV/mm	ASTM D149
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.

NOTE

1. Method A (short time)

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