

Plaslube® PA6/6 GF30 TL5 LE

Polyamide 66
Techmer Engineered Solutions

Message:

Plaslube® PA6/6 GF30 TL5 LE is a polyamide 66 (nylon 66) product, which contains a 30% glass fiber reinforced material. It can be processed by injection molding and is available in North America. Typical application areas are: food contact applications.

Features include:

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

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	PTFE lubricant (15%)		
Features	Low extract		
	Low friction coefficient		
	Good wear resistance		
	Lubrication		
Agency Ratings	FDA not rated		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Water Absorption (24 hr)	0.50	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	90		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	149	MPa	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	8960	MPa	ASTM D790
Flexural Strength	224	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
With steel-dynamic	0.28		ASTM D1894
With steel-static	0.22		ASTM D1894
Wear Factor	36	10 ⁻⁸ mm ³ /N · m	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	75	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	254	°C	ASTM D648
CLTE - Flow	2.7E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength ¹	20	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Additional Information	Nominal Value	Unit	

175001000 fpm

20000100 fpm

Limiting Pressure Velocity 1750010 fpm psi-ft/min

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.

NOTE

- Method A (short time)

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