Tribocomp® PA66 LGF30 N9 PTFE 15% MoS 0.5%

Polyamide 66

Solvay Specialty Polymers

Message:

Tribocomp® PA66 LGF30 N9 PTFE 15% MoS 0.5%, is a 30% long glass fiber reinforced high-flow PA 6.6 with a pellet length of 9mm and contains 15% PTFE and 0.5% MoS2. It can easily be processed on most injection molding machines.

General Information				
Filler / Reinforcement	PTFE fiber, 15% filler by weight Long glass fiber, 30% filler by weight			
Forms	Particle			
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.50	--	g/cm³	ISO 1183
shrinkage-Flow	0.40	--	%	ISO 294-4
Water Absorption (Equilibrium, 23°C, 50% RH)	1.4	--	%	ISO 62
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus				ISO 527-2
23°C	10500	7900	MPa	ISO 527-2
90°C	7100	--	MPa	ISO 527-2
120°C	5500	--	MPa	ISO 527-2
Tensile Stress				ISO 527-2
Yield, 23°C	200	125	MPa	ISO 527-2
Yield, 90°C	130	--	MPa	ISO 527-2
Yield, 120°C	105	--	MPa	ISO 527-2
Tensile Strain (Break)	3.0	--	%	ISO 527-2
Flexural Modulus (23°C)	8300	6200	MPa	ISO 178
Flexural Stress (23°C)	260	200	MPa	ISO 178
Coefficient of Friction				ASTM D3702
Dynamic	0.23	--		ASTM D3702
Static	0.18	--		ASTM D3702
Wear Factor	13.0	--		ASTM D3702
Coefficient of Linear Thermal Expansion	1.9E-5	--	cm/cm/°C	ISO 11359-2
Surface Resistivity	1.0E+13	--	ohms/sq	ASTM D257
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	19	--	kJ/m²	ISO 179

Charpy Unnotched Impact Strength (23°C)	65	--	kJ/m²	ISO 179
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
0.45 MPa, not annealed	255	--	°C	ISO 75-2/B
1.8 MPa, not annealed	253	--	°C	ISO 75-2/A
Thermal Conductivity	0.29	--	W/m/K	ISO 22007
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Dielectric Strength (2.00 mm)	35	--	kV/mm	IEC 60243-1
Comparative Tracking Index	500	--	V	IEC 60112

Additional Information

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The value listed as Molding Shrinkage ISO 294-4, was tested in accordance with S.O.P. methods.

Injection	Dry	Unit
Drying Temperature	100	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	270 - 300	°C
Middle Temperature	270 - 300	°C
Front Temperature	285 - 300	°C
Nozzle Temperature	285 - 310	°C
Processing (Melt) Temp	< 300	°C
Mold Temperature	80 - 160	°C

Injection instructions

Pre-drying -- Since polyamides are hygroscopic materials as well as sensitive to moisture during processing, this product should always be pre-dried. At a humidity content above 0.1%, the material will begin to degrade. Recommended drying time is 4 hours at 100°C in dry-air dryer.Processing temperatures -- Melt temperature should be kept below 300°C in order to prevent degradation. The exact setting depends from machine and mold design, but is usually within the following range:Area | RecommendationZone 1 (feed) 270-300°C | 280°CZone 2 (middle) 270-300°C | 290°CZone 3 (front) 285-300°C | 295°CZone 4 (Nozzle) 285-310°C | 300°CMold temperature -- The mold temperature is a compromise between the optimum properties that can be obtained from high crystallization, and cycle time. This material can be processed at mold temperatures between 80°C and 160°C. Optimum surface quality requires a mold temperature above 120°C.Regrind -- Regrind of highly filled thermoplastic materials, such as this material, should only be recycled with special care. The regrind content must never exceed 15%, and only regrind of optimum quality should be used. In any case, part properties should be checked.

Recommended distributors for this material

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