

LubriOne™ NN-000/15T BK204

Polyamide 66
PolyOne Corporation

Message:
PTFE lubricated PA66 compound.

General Information			
UL YellowCard	E76261-101455000	E76261-101454999	
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	70.0	MPa	ASTM D638
Flexural Modulus ¹	2400	MPa	ASTM D790
Flexural Strength ²	105	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 (1.6 mm)	HB		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	80 - 90	°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 - 85	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	1.3 mm/min		

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