

Plaslube® PA6/6 GF33 TL15

Polyamide 66

Techmer Engineered Solutions

Message:

Plaslube® PA6/6 GF33 TL15 is a polyamide 66 (nylon 66) product, which contains a 33% glass fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

Wear-resistant

heat stabilizer

Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 33% filler by weight		
Additive	PTFE lubricant (15%) heat stabilizer		
Features	Low friction coefficient Good wear resistance Thermal Stability Lubrication		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.50	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)	80	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	1.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength ¹	22	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (11.5 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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