

Plaslube® PA6/6 GF10 M/TL10

Polyamide 66
Techmer Engineered Solutions

Message:

Plaslube® PA6/6 GF10 M/TL10 is a polyamide 66 (nylon 66) product, which contains a 10% glass fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

- flame retardant/rated flame
- Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Additive	PTFE lubricant		
	Molybdenum disulfide lubricant		
Features	Lubrication		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.70	%	ASTM D955
Water Absorption (24 hr)	0.75	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	77.2	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	3520	MPa	ASTM D790
Flexural Strength	103	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
With steel-dynamic	0.26		ASTM D1894
With steel-static	0.21		ASTM D1894
Wear Factor	26	10 ⁻⁸ mm ³ /N · m	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	232	°C	ASTM D648
CLTE - Flow	5.4E-5	cm/cm/°C	ASTM D696

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.0E+14	ohms·cm	ASTM D257
Dielectric Strength ¹	19	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Additional Information	Nominal Value	Unit	

95001000 fpm

10000100 fpm

Limiting Pressure Velocity 950010 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

1. Method A (short time)

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