

TECHNICAL DATA AND PROCESS SHEET

20% GLASS FIBER REINFORCED 15% PTFE LUBRICATED NYLON 6/6

INLUBE PA66GF20TF15

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.39		1.39	
SPECIFIC VOLUME		19.93	in ³ /lb	0.719	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.90	%	0.90	%
MOLD SHRINKAGE	D955	0.4-0.8	%	0.4-0.8	%
MECHANICAL					
TENSILE STRENGTH	D638	18,500	psi	128	MPa
ELONGATION, YIELD	D638	3-4	%	3-4	%
FLEXURAL STRENGTH	D790	28,000	psi	193	MPa
FLEXURAL MODULUS	D790	1,000,000	psi	6,895	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.5	ft.lb./in.	80	J/m
UNNOTCHED 1/8"		12	ft.lb./in.	640	J/m
ROCKWELL HARDNESS		M93	M Scale	M93	M Scale
THERMAL					
HDTUL	D648	460	°F	238	°C
@ 264 PSI					
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.7	in./in. F x10 ⁻⁵	4.86	mm/mm C 10 ⁻⁶
FLAMMABILITY ¹	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e16	ohms/sq	10e16	ohms/sq
PROCESSING					
DRYING TEMPERATURE		175	°F	79	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		500-575	°F	260 - 301	°C
MOLD TEMPERATURE		200	°F	93	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0005-0.001	in	0.0125 - 0.025	mm

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