

TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED 15% PTFE LUBRICATED IMPACT MODIFIED NYLON 6/6

INLUBE PA66GF30TF15IM

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.42		1.42	
SPECIFIC VOLUME		19.51	in ³ /lb	0.704	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.80	%	0.80	%
MOLD SHRINKAGE	D955	0.4-0.6	%	0.4-0.6	%
MECHANICAL					
TENSILE STRENGTH	D638	12,500	psi	86	MPa
ELONGATION, YIELD	D638	1-3	%	1-3	%
FLEXURAL STRENGTH	D790	22,000	psi	152	MPa
FLEXURAL MODULUS	D790	750,000	psi	5,171	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		3.8	ft.lb./in.	203	J/m
UNNOTCHED 1/8"		16	ft.lb./in.	853	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL	D648	470	°F	243	°C
@ 264 PSI					
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.2	in./in. F x10 ⁻⁵	3.96	mm/mm C 10 ⁻⁶
FLAMMABILITY ¹	U.L.Subj 94	HB@ 1/16	in	HB@ 1.5	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e ¹⁶	ohms/sq	10e ¹⁶	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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