Engineered Compounds
tel 856.467.3030 fax 856.467.3033
2079 Center Square Road Swedesboro, NJ 08085

TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED 13% PTFE 2% SILICONE LUBRICATED NYLON 6

INLUBE PA6GF30TF13SI2

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.47		1.47	
SPECIFIC VOLUME		18.84	in^3/lb	0.680	cm^3/gm
WATER ABSORPTION (24 Hrs	D570	0.50	%	0.50	%
MOLD SHRINKAGE	D955	0.3-0.4	%	0.3-0.4	%
MECHANICAL					
TENSILE STRENGTH	D638	17,500	psi	121	MPa
ELONGATION, YIELD	D638	2-4	%	2-4	%
FLEXURAL STRENGTH	D790				
FLEXURAL MODULUS	D790	1,100,000	psi	7,584	MPa
SHEAR STRENGTH	D732	11,000	psi	76	MPa
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.8	ft.lb./in.	96	J/m
UNNOTCHED 1/8"		20	ft.lb./in.	1066	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL @ 264 PSI	D648	410	°F	210	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.3	in./in. F $x10^{-5}$	4.14	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		480-550	°F	250 - 290	°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