

TECHNICAL DATA AND PROCESS SHEET

2% SILICONE LUBRICATED NYLON 6

INLUBE PA6SI2

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.12		1.12	
SPECIFIC VOLUME		24.73	in ³ /lb	0.893	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	1.50	%	1.50	%
MOLD SHRINKAGE	D955	1.3-1.6	%	1.3-1.6	%
MECHANICAL					
TENSILE STRENGTH	D638	10,500	psi	72	MPa
ELONGATION, YIELD	D638	>50	%	>50	%
FLEXURAL STRENGTH	D790				
FLEXURAL MODULUS	D790	400,000	psi	2,758	MPa
SHEAR STRENGTH	D732	9,500	psi	66	MPa
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.1	ft.lb./in.	59	J/m
UNNOTCHED 1/8"		30	ft.lb./in.	1599	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL @ 264 PSI	D648	160	°F	71	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	4.6	in./in. F x 10 ⁻⁵	8.28	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

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