

**TECHNICAL DATA AND PROCESS SHEET**

**20% PTFE LUBRICATED NYLON 6**

**INLUBE PA6TF20**

**TYPICAL PROPERTIES**

<b>PROPERTY</b>	<b>ASTM METHOD</b>	<b>English</b>	<b>UNITS</b>	<b>Metric SI</b>	<b>UNITS</b>
<b>GENERAL</b>					
SPECIFIC GRAVITY	D792	1.26		1.26	
SPECIFIC VOLUME		21.98	in <sup>3</sup> /lb	0.794	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	1.10	%	1.10	%
MOLD SHRINKAGE	D955	1.3-1.6	%	1.3-1.6	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	8,500	psi	59	MPa
ELONGATION, YIELD	D638	8-10	%	8-10	%
FLEXURAL STRENGTH	D790				
FLEXURAL MODULUS	D790	300,000	psi	2,068	MPa
SHEAR STRENGTH	D732	9,000	psi	62	MPa
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1	ft.lb./in.	53	J/m
UNNOTCHED 1/8"		15	ft.lb./in.	800	J/m
ROCKWELL HARDNESS					
<b>THERMAL</b>					
HDTUL	D648	160	°F	71	°C
@ 264 PSI					
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	4.7	in./in. F x 10 <sup>-5</sup>	8.46	mm/mm C 10 <sup>-6</sup>
FLAMMABILITY <sup>1</sup>	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
<b>ELECTRICAL</b>					
SURFACE RESISTIVITY		10e <sup>16</sup>	ohms/sq	10e <sup>16</sup>	ohms/sq
<b>PROCESSING</b>					
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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