Infinity LTL™
Engineered Compounds
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2079 Center Square Road Swedesboro, NJ 08085

TECHNICAL DATA AND PROCESS SHEET

10% GLASS FIBER REINFORCED NYLON 610

INSTRUC PA610GF10

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.15		1.15	
SPECIFIC VOLUME		24.09	in^3/lb	0.870	cm^3/gm
WATER ABSORPTION (24 Hrs	D570	0.25	%	0.25	%
MOLD SHRINKAGE	D955	0.45-0.6	%	0.45-0.6	%
MECHANICAL					
TENSILE STRENGTH	D638	12,000	psi	83	MPa
ELONGATION, YIELD	D638	3-4	%	3-4	%
FLEXURAL STRENGTH	D790	20,000	psi	138	MPa
FLEXURAL MODULUS	D790	750,000	psi	5,171	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1	ft.lb./in.	53	J/m
UNNOTCHED 1/8"		7	ft.lb./in.	373	J/m
ROCKWELL HARDNESS		M87	M Scale	M87	M Scale
THERMAL					
HDTUL @ 264 PSI	D648	400	°F	204	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.5	in./in. F $x10^{-5}$	4.5	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		460-525	°F	238 - 275	°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