

TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED, 15% PTFE LUBRICATED NYLON 6

INLUBE PA6GF30TF15

TYPICAL PROPERTIES

| PROPERTY | ASTM METHOD | English | UNITS | Metric SI | UNITS |
|--|--------------------|-------------------|------------------------------|-------------------|--------------------------|
| GENERAL | | | | | |
| SPECIFIC GRAVITY | D792 | 1.49 | | 1.49 | |
| SPECIFIC VOLUME | | 18.59 | in ³ /lb | 0.671 | 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 | 19,000 | psi | 131 | MPa |
| ELONGATION, YIELD | D638 | 2-4 | % | 2-4 | % |
| FLEXURAL STRENGTH | D790 | | | | |
| FLEXURAL MODULUS | D790 | 1,200,000 | psi | 8,274 | MPa |
| SHEAR STRENGTH | D732 | 11,000 | psi | 76 | MPa |
| IZOD IMPACT STRENGTH | D256 | | | | |
| NOTCHED 1/8" | | 1.9 | ft.lb./in. | 101 | 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 x 10 ⁻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 |

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