

Plaslube® PA6/6 GF13 ML2

Polyamide 66
Techmer Engineered Solutions

Message:

Plaslube®PA6/6 GF13 ML2 is a polyamide 66 (nylon 66) product, which contains a 13% glass fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

- heat stabilizer
- Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 13% filler by weight		
Additive	Molybdenum disulfide lubricant (2%) heat stabilizer		
Features	Thermal Stability Lubrication		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	1.8	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	110	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	4900	MPa	ASTM D790
Flexural Strength	167	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
With steel-dynamic	0.31		ASTM D1894
With steel-static	0.24		ASTM D1894
Wear Factor	150	10 ⁻⁸ mm ³ /N · m	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	255	°C	ASTM D648

1.8 MPa, not annealed	221	°C	ASTM D648
CLTE - Flow	3.2E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength ¹	19	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	282 - 293	°C	
Middle Temperature	288 - 299	°C	
Front Temperature	277 - 288	°C	
Nozzle Temperature	271 - 304	°C	
Processing (Melt) Temp	282 - 304	°C	
Mold Temperature	79.4 - 104	°C	
Injection Rate	Slow-Moderate		
Back Pressure	0.00 - 0.345	MPa	
Injection instructions			
Screw Speed: SlowRecommendations for Molding and Tool Conditions: Well vented moldMoisture Content, as received: Product is packaged at 0.2% or less.			
NOTE			
1.	Method A (short time)		

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