

LubriOne™ NN-30CF/13T-2S BK004

Polyamide 66
PolyOne Corporation

Message:
Carbon fiber reinforced, PTFE & silicon lubricated PA66 compound.

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 30% filler by weight		
Additive	PTFE lubricant (13%)		
	Silicone lubricant (2%)		
Features	Lubrication		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792
Molding Shrinkage	0.10 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	190	MPa	ASTM D638
Flexural Modulus ²	18000	MPa	ASTM D790
Flexural Strength ³	300	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	85	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	250	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	10 - 1.0E+4	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			Internal method
0.750 mm	HB		Internal method
1.50 mm	HB		Internal method
3.00 mm	HB		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	260 - 280	°C	
Middle Temperature	260 - 280	°C	
Front Temperature	260 - 280	°C	
Mold Temperature	65.0 - 85.0	°C	

Injection instructions

Injection Pressure: MED-HIGH Hold Pressure: MED-HIGH Screw Speed: MODERATE Back Pressure: LOW

NOTE

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|----|------------|
| 1. | 5.0 mm/min |
| 2. | 1.3 mm/min |
| 3. | 1.3 mm/min |

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