



Phone: (517) 295-4196 Fax: (517) 295-4918

## Technical Data Sheet

### LCA® N6-13GFLU Black

#### Nylon 6 13% Glass Fiber, Lubricated, Utility grade

Typical Compound Properties	Value / Measure	Test Methods
<b>Physical Properties</b>		
Density	1.23 g/cm <sup>3</sup>	ASTM D-792
Ash Content	13 %	ASTM D-5630
<b>Mechanical Properties</b>		
Izod Impact	1.0 ft-lb/in	ASTM D-256
Tensile Strength	14,500 psi	ASTM D-638
Flexural Modulus	600,000 psi	ASTM D-790
<b>Thermal Properties</b>		
Melt Point	220° C	ASTM D-789-92e1

All tests are performed on dry as molded ASTM (ISO) test bars.

**General Product Type Information**

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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Typical Processing Conditions		
Process Variable	Description	Values
<b>Temperatures</b>		<b>F C</b>
Barrel	Rear	460 - 540
	Center	480 - 560
	Front	480 - 560
	Nozzle	470 - 550
	Mold	175 - 205
<b>Drying</b>		
Type		Dehumidifier
Temperature		175°F
Time		2 - 4 hours
Max. % Moisture		0.2
<b>Special Requirements</b>		
Meets GMP.PA6.006		

Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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