



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

Technical Data Sheet

LCA® N6-33GF HSL

Nylon 6, 33% Glass Fiber, Heat Stabilized, Lubricated

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties			
	English Units (ISO)	Metric Units	
Density	1.39 g/cm ³	1.39 g/cm ³	ASTM D-792
Ash Content	33 %	%	ASTM D-5630
Linear Mold Shrinkage	in/in	mm/mm	ASTM D-955
Mechanical Properties			
Izod Impact - Notched (Minimum)	1 ft-lb/in (kJ/m ²)	53 J/m	ASTM D-256
Tensile Strength @ Yield	20,000 psi	138 MPa	ASTM D-638
Tensile Strength @ Break (Minimum)	psi	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	%	ASTM D-638
Tensile Elongation @ Break	9 %	%	ASTM D-638
Flexural Strength @ Yield	psi (Mpa)	0 MPa	ASTM D-790
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790
Flexural Modulus (Minimum)	1,000,000 psi (Mpa)	6,900 MPa	ASTM D-790
Thermal Properties			
DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	Deg. F	Deg. C	ASTM D-648
Vicat Softening Temperature	Deg. F	Deg. C	ASTM D-1525
Melt Point	421 Deg. F	216 Deg. 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	
Temperatures		F	C
Barrel	Rear	460 - 540	
	Center	480 - 560	
	Front	480 - 560	
	Nozzle	470 - 550	
	Mold	175 - 205	
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Drying			
Type		Dehumidifier	
Temperature		175°F	
Time		2 - 4 hours	
Max. % Moisture		0.2	
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Special Requirements			
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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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