



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

## Technical Data Sheet

### LCA® N66-25GFXL Black

#### Nylon 66 25% Glass Fiber, Lubricated at .4%

Typical Compound Properties	Value / Measure		Test Methods
<b>Physical Properties</b>			
	English Units (ISO)	Metric Units	
Density	1.31 g/cm <sup>3</sup>	1.31 g/cm <sup>3</sup>	ASTM D-792
Ash Content	25 %	25 %	ASTM D-5630
Linear Mold Shrinkage	in/in	0 mm/mm	ASTM D-955
<b>Mechanical Properties</b>			
Izod Impact - Notched	0.90 ft-lb/in (kJ/m <sup>2</sup> )	48 J/m	ASTM D-256
Tensile Strength @ Yield	17,000 psi (Mpa)	117 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	11 %	11 %	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	950,000 psi (Mpa)	6,555 MPa	ASTM D-790
<b>Thermal Properties</b>			
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	32 Deg. F	Deg. C	ASTM D-1525
Melt Point	482 Deg. F	250.00 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	
<b>Temperatures</b>		<b>F</b>	<b>C</b>
Barrel	Rear	540 - 580	
	Center	530 - 570	
	Front	520 - 570	
	Nozzle	510 - 560	
	Mold	150 - 250	
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<b>Drying</b>			
Type		Dehumidifier	
Temperature		175°F	
Time		2 - 4 hours	
Max. % Moisture		0.2	
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<b>Special Requirements</b>			
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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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