

Electrafil® PA6 GF20

Polyamide 6
Techmer Engineered Solutions

Message:

Electrafil® PA6 GF20 is a polyamide 6 (nylon 6) product, which contains 20% glass fiber reinforced materials and fillers. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

Conductivity

Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight Filler		
Additive	Lubricant		
Features	Conductivity Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.70	%	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	117	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	8270	MPa	ASTM D790
Flexural Strength	190	MPa	ASTM D790
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 (1.8 MPa, Unannealed)	210	°C	ASTM D648
CLTE - Flow	5.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2 - 1.0E+5	ohms	ASTM D257
Volume Resistivity	1.0E+4 - 1.0E+7	ohms · cm	ASTM D257

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	266 - 277	°C	
Middle Temperature	277 - 288	°C	
Front Temperature	271 - 282	°C	
Nozzle Temperature	271 - 282	°C	
Processing (Melt) Temp	277 - 288	°C	
Mold Temperature	79.4 - 104	°C	
Injection Rate	Slow-Moderate		
Back Pressure	0.00 - 0.345	MPa	
Injection instructions			

Screw Speed: Medium Recommendations for Molding and Tool Conditions: Well vented mold Moisture Content, as received: Product is packaged at 0.2% or less.

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