

Electrafil® PA6/6 GF13 SS10 BK

Polyamide 66
Techmer Engineered Solutions

Message:

Electrafil® PA6/6 GF13 SS10 BK is a polyamide 66 (nylon 66) product, which contains 13% glass fiber reinforced materials and 10% stainless steel fibers. It can be processed by injection molding and is available in North America.

Features include:

- flame retardant/rated flame
- Electromagnetic shielding (EMI)

| General Information | | | |
|---|--|-------------------|-------------|
| Filler / Reinforcement | Glass fiber reinforced material, 13% filler by weight Stainless steel fiber, 10% filler by weight | | |
| Features | Electromagnetic shielding (EMI) | | |
| Appearance | Black | | |
| Forms | Particle | | |
| Processing Method | Injection molding | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 1.27 | g/cm ³ | ASTM D792 |
| Molding Shrinkage - Flow (3.18 mm) | 0.60 | % | ASTM D955 |
| Water Absorption (24 hr) | 0.60 | % | ASTM D570 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Strength (Break) | 96.5 | MPa | ASTM D638 |
| Tensile Elongation (Break) | 3.0 | % | ASTM D638 |
| Flexural Modulus | 5450 | MPa | ASTM D790 |
| Flexural Strength | 148 | MPa | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (23°C, 3.18 mm) | 53 | J/m | ASTM D256 |
| Unnotched Izod Impact (3.18 mm) | 480 | J/m | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 249 | °C | ASTM D648 |
| Electrical | Nominal Value | Unit | Test Method |
| Surface Resistivity | 1.0E+4 | ohms | ASTM D257 |
| Volume Resistivity | 1.0E+4 | ohms · cm | ASTM D257 |
| EMI Attenuation | 40 | dB | ASTM D4935 |
| Static Decay | | sec | FTMS 101B |
| 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 | 282 - 293 | °C |
| Middle Temperature | 288 - 299 | °C |
| Front Temperature | 277 - 288 | °C |
| Nozzle Temperature | 271 - 304 | °C |
| Processing (Melt) Temp | 282 - 304 | °C |
| Mold Temperature | 79.4 - 104 | °C |
| Injection Rate | Slow-Moderate | |
| Back Pressure | 0.00 - 0.345 | MPa |

Injection instructions

Screw Speed: Slow 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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