

Tarnamid® T- 27 CFHI

Polyamide 6

Grupa Azoty S.A.

Message:

It is reinforced polyamide 6 compound, heat stabilised and impact modified., good conductive and electrostatic properties.

General Information				
Filler / Reinforcement		Carbon Fiber,8.0% Filler by Weight		
Additive		Heat Stabilizer		
		Impact Modifier		
Features		Antistatic		
		Electrically Conductive		
		Heat Stabilized		
		Impact Modified		
Uses		Mining Applications		
Appearance		Black		
		Natural Color		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.11	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	35.0	--	cm ³ /10min	ISO 1133
Molding Shrinkage				ISO 294-4
Across Flow : 2.00 mm	1.4	--	%	
Flow : 2.00 mm	1.1	--	%	
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	120	90.0	MPa	ISO 2039-1
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5500	4000	MPa	ISO 527-2/1
Tensile Stress (Yield)	90.0	70.0	MPa	ISO 527-2/5
Tensile Strain (Break)	6.0	13	%	ISO 527-2/5
Flexural Modulus ¹	4000	3300	MPa	ISO 178
Flexural Stress ²	100	75.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	11	15	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength	80	120	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength	12	15	kJ/m ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	170	170	°C	ISO 75-2/A
Vicat Softening Temperature	180	165	°C	ISO 306/B
Melting Temperature	221	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C	1.0E-5	--	cm/cm/°C	
Transverse : 23 to 55°C	1.9E-4	--	cm/cm/°C	
Limit of Temperature - a few hours operation	180	--	°C	
Temperature Index - 20000 hr	120	--	°C	
Burning Rate	+	--		FMVSS 302
ISO Type	PA6, MHRZ, 14-050, CF8	--		ISO 1874
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+10	--	ohms	IEC 60093
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
1.60 mm	HB	--		
3.20 mm	HB	--		
Injection	Dry	Unit		
Drying Temperature	< 80.0		°C	
Suggested Max Moisture	< 0.10		%	
Suggested Max Regrind	10		%	
Processing (Melt) Temp	240 to 260		°C	
Mold Temperature	60.0 to 80.0		°C	
Injection Pressure	80.0 to 110		MPa	
Injection Rate	Moderate			
NOTE				
1.	2.0 mm/min			
2.	2.0 mm/min			

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