

Electrafil® PA6/6 03002 CF

Polyamide 66
Techmer Engineered Solutions

Message:

Electrafil® PA6/6 03002 CF is a polyamide 66 (nylon 66) product, which contains carbon fiber reinforcement. It can be processed by injection molding and is available in North America.

Features include:

- Impact modification
- Conductivity
- Impact resistance
- heat stabilizer
- Lubrication

General Information			
Filler / Reinforcement	Carbon fiber reinforced material		
Additive	Impact modifier		
	heat stabilizer		
	Lubricant		
Features	Conductivity		
	Impact resistance, high		
	Thermal Stability		
	Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.70	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	111		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	155	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	11000	MPa	ASTM D790
Flexural Strength	193	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	170	J/m	ASTM D256
Unnotched Izod Impact (3.81 mm)	1000	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	252	°C	ASTM D648
1.8 MPa, not annealed	220	°C	ASTM D648
CLTE - Flow	4.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0 - 1.0E+3	ohms	ASTM D257
Volume Resistivity	1.0 - 1.0E+3	ohms·cm	ASTM D257
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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