

# HiFill® PA6 CF20 RM BK

Polyamide 6  
Techmer Engineered Solutions

Message:

HiFill® PA6 CF20 RM BK is a Polyamide 6 (Nylon 6) product filled with 20% carbon fiber. It can be processed by injection molding and is available in North America. Primary characteristic: low moisture absorption.

General Information			
Filler / Reinforcement	Carbon Fiber,20% Filler by Weight		
Features	Low Moisture Absorption		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.40	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	138	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	6890	MPa	ASTM D790
Flexural Strength	207	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	85	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	204	°C	ASTM D648
CLTE - Flow	2.0E-5	cm/cm/°C	ASTM D696
Additional Information	Nominal Value		
TPCI #	9720102		
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	260 to 304	°C	
Middle Temperature	260 to 304	°C	
Front Temperature	260 to 304	°C	
Processing (Melt) Temp	243 to 271	°C	
Mold Temperature	65.6 to 93.3	°C	
Back Pressure	0.00 to 0.345	MPa	

Screw Speed

30 to 60

rpm

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#### Recommended distributors for this material

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