HiFill® PA6 CF30

Polyamide 6

Techmer Engineered Solutions

Message:

HiFill® PA6 CF30 is a Polyamide 6 (Nylon 6) product filled with 30% carbon fiber. It can be processed by injection molding and is available in North America.

General Information			
Filler / Reinforcement	Carbon Fiber,30% Filler by Weight		
Appearance	Black		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	214	MPa	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	17200	MPa	ASTM D790
Flexural Strength	310	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	110	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	216	°C	
1.8 MPa, Unannealed	210	°C	
CLTE - Flow	2.3E-5	cm/cm/°C	ASTM D696

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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