

# Electrafil® PA6 04001 BK MB

Polyamide 6  
Techmer Engineered Solutions

Message:

Electrafil® PA6 04001 BK MB is a polyamide 6 (nylon 6) product, which contains glass fiber reinforced materials and 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)
- Lubrication
- radio frequency shielding (RFI)

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
	Stainless steel fiber		
Additive	Lubricant		
Features	Electromagnetic shielding (EMI)		
	Lubrication		
	Radio frequency shielding (RFI)		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20	%	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	138	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	7580	MPa	ASTM D790
Flexural Strength	193	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)	210	°C	ASTM D648
CLTE - Flow	5.4E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method

Surface Resistivity	10 - 1.0E+3	ohms	ASTM D257
Volume Resistivity	1.0 - 10	ohms·cm	ASTM D257
EMI Attenuation	50	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	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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#### Recommended distributors for this material

### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

