

Electrafil® J-71/CF/20/EG NATL

Techmer Polymer Modifiers - *Polyamide 6*

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 20% Filler by Weight
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	21100	psi	ISO 527-2

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (0.125 in)	3.0	ft·lb/in ²	ISO 180

Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+4	ohms	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	470 to 500	°F
Middle Temperature	480 to 510	°F
Front Temperature	490 to 520	°F
Nozzle Temperature	500 to 530	°F
Processing (Melt) Temp	480 to 525	°F
Mold Temperature	100 to 200	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

