

Electrafil® J-71/CF/20/EG

Techmer Polymer Modifiers - *Polyamide 6 Alloy*

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Carbon Fiber, 20% Filler by Weight
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.19		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-4	in/in	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 73°F)	24000	psi	ASTM D638
Tensile Elongation (Break, 73°F)	2.5	%	ASTM D638
Flexural Modulus (73°F)	2.00E+6	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.3	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	400	°F	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	50	ohms	ASTM D257
Additional Information	Surface Resistivity, ASTM D4496: 10-100 ohms/sq		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	220	°F
Drying Time	2.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	485 to 520	°F
Middle Temperature	500 to 530	°F
Front Temperature	490 to 520	°F
Nozzle Temperature	490 to 520	°F
Processing (Melt) Temp	485 to 530	°F
Mold Temperature	130 to 180	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi

