Electrafil® PA6/6 03004 GF20

Techmer Polymer Modifiers - *Polyamide 66*

General			
Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Carbon Fiber	• Glass Fiber, 20% Filler by Weight	
Additive	• Heat Stabilizer	• Impact Modifier	• Lubricant
Features	• Heat Stabilized • High Impact Resistance	• Lubricated • Statically Conductive	
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.30		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.020	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	18000	psi	ASTM D638
Tensile Elongation (Break)	2.3	%	ASTM D638
Flexural Modulus	1.01E+6	psi	ASTM D790
Flexural Strength	26100	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	1.2	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.150 in)	19	ft·lb/in	ASTM D4812
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	111		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	497	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	466	°F	ASTM D648
CLTE - Flow	2.2E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+3 to 1.0E+8	ohms	ASTM D257
Volume Resistivity	1.0E+3 to 1.0E+8	ohms·cm	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	510 to 530	°F
Middle Temperature	530 to 550	°F
Front Temperature	520 to 540	°F
Nozzle Temperature	520 to 540	°F
Processing (Melt) Temp	530 to 550	°F
Mold Temperature	175 to 220	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi

Injection Notes

Screw Speed: Medium
Recommendations for Molding and Tool Conditions: Well vented mold
Moisture Content, as received: Product is packaged at 0.2% or less.