

Electrafil® J-1/CF/10/TF/13/SI/2

Techmer Polymer Modifiers - Polyamide 66

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Carbon Fiber, 10% Filler by Weight
Additive	• PTFE Lubricant: 13% • Silicone Lubricant: 2%
Features	• Lubricated
RoHS Compliance	• RoHS Compliant
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.25		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (73°F)	19000	psi	ASTM D638
Flexural Modulus (73°F)	1.10E+6	psi	ASTM D790
Flexural Strength (73°F)	26000	psi	ASTM D790
Compressive Strength	20000	psi	ASTM D695
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.60	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	475	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	550 to 570	°F
Middle Temperature	560 to 580	°F
Front Temperature	540 to 560	°F
Nozzle Temperature	530 to 550	°F
Processing (Melt) Temp	560 to 580	°F
Mold Temperature	175 to 220	°F
Injection Rate	Moderate	
Back Pressure	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.

