

Electrafil® J-1/CF/30/TF/13/SI/2 NATL

Techmer Polymer Modifiers - Polyamide 66

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.38		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3.30E+6	psi	ASTM D638
Tensile Strength (Yield)	24000	psi	ASTM D638
Tensile Elongation (Break)	1.2	%	ASTM D638
Flexural Modulus	2.10E+6	psi	ASTM D790
Flexural Strength	34000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.3	ft·lb/in	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	< 1.0E+4	ohms·cm	ASTM C611

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	510 to 540	°F
Middle Temperature	520 to 550	°F
Front Temperature	530 to 560	°F
Nozzle Temperature	540 to 570	°F
Processing (Melt) Temp	520 to 565	°F
Mold Temperature	175 to 250	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

