

## Electrafil® PA6/10 CF30 IM BK

Techmer Polymer Modifiers - Polyamide 610

### General

|                        |                                      |
|------------------------|--------------------------------------|
| Material Status        | • Commercial: Active                 |
| Availability           | • North America                      |
| Filler / Reinforcement | • Carbon Fiber, 30% Filler by Weight |
| Additive               | • Impact Modifier                    |
| Features               | • Impact Modified                    |
| Appearance             | • Black                              |
| Processing Method      | • Injection Molding                  |

### Properties <sup>1</sup>

| Physical                       | Nominal Value    | Unit     | Test Method |
|--------------------------------|------------------|----------|-------------|
| Density / Specific Gravity     | 1.18             |          | ASTM D792   |
| Mechanical                     | Nominal Value    | Unit     | Test Method |
| Tensile Modulus                | 2.50E+6          | psi      | ASTM D638   |
| Tensile Strength (Yield)       | 20000            | psi      | ASTM D638   |
| Tensile Strength (Break)       | 20000            | psi      | ASTM D638   |
| Tensile Elongation (Break)     | 4.5              | %        | ASTM D638   |
| Flexural Modulus               | 2.00E+6          | psi      | ASTM D790   |
| Flexural Strength              | 33000            | psi      | ASTM D790   |
| Impact                         | Nominal Value    | Unit     | Test Method |
| Notched Izod Impact (0.125 in) | 4.3              | ft-lb/in | ASTM D256   |
| Electrical                     | Nominal Value    | Unit     | Test Method |
| Surface Resistivity            | 1.0E+2 to 1.0E+6 | ohms     | ASTM D257   |

### Processing Information

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature     | 180           | °F   |
| Drying Time            | 2.0 to 3.0    | hr   |
| Rear Temperature       | 460 to 490    | °F   |
| Middle Temperature     | 470 to 500    | °F   |
| Front Temperature      | 480 to 510    | °F   |
| Nozzle Temperature     | 490 to 520    | °F   |
| Processing (Melt) Temp | 470 to 520    | °F   |
| Mold Temperature       | 75 to 150     | °F   |
| Injection Rate         | Slow          |      |
| Back Pressure          | 0.00 to 50.0  | psi  |
| Screw Speed            | Slow-Moderate |      |

