

Electrafil® PA6 11002 FR-NQ BK - A1

 Techmer Polymer Modifiers - *Polyamide 6*
General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber
Additive	• Flame Retardant
Features	• Conductive • Flame Retardant
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.25		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.70E+6	psi	ASTM D638
Tensile Strength (Yield)	15500	psi	ASTM D638
Tensile Strength (Break)	15500	psi	ASTM D638
Tensile Elongation (Break)	2.6	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft·lb/in	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+6	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.12 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	460 to 500	°F
Middle Temperature	470 to 510	°F
Front Temperature	480 to 520	°F
Nozzle Temperature	490 to 530	°F
Processing (Melt) Temp	470 to 525	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

