Electrafil® J-1/CF/15/TF/20

Techmer Polymer Modifiers - *Polyamide 66*

General Information

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Carbon Fiber, 15% Filler by Weight		
Additive	• PTFE Lubricant: 20%		
Features	• Lubricated		
Uses	• Automotive Electronics • Bushings	• Business Equipment • Conveyor Parts	• Packaging
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.33		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.60E+6	psi	ASTM D638
Tensile Strength (Break, 73°F)	24000	psi	ASTM D638
Flexural Modulus (73°F)	1.50E+6	psi	ASTM D790
Flexural Strength (Break, 73°F)	34500	psi	ASTM D790
Compressive Strength	20000	psi	ASTM D695
Shear Strength	11000	psi	ASTM D732
Coefficient of Friction (vs. Steel - Static)	0.11		ASTM D1894
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	1.4	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	495	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	482	°F	ASTM D648
CLTE - Flow	1.3E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	5.0E+2	ohms	ASTM D257
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	HB		UL 94
Additional Information			
Surface Resistivity, ASTM D257: 1E2-1E3 ohm/sq			

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	165 to 220	°F
Drying Time	2.0 to 16	hr
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 540	°F

Processing (Melt) Temp	540 to 580 °F
Mold Temperature	130 to 200 °F

Notes

[1] Typical properties: these are not to be construed as specifications.