

**Electrafil® PA6/6 03002 A MB**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
**General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Filler • Glass Fiber
Additive	• Heat Stabilizer • Impact Modifier • Lubricant
Features	• Conductive • High Impact Resistance • Heat Stabilized • Lubricated
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.23		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.012	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength (Yield)	12200	psi	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Flexural Modulus	525000	psi	ASTM D790
Flexural Strength	16000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	2.0	ft·lb/in	
73°F, 0.125 in	2.8	ft·lb/in	
Unnotched Izod Impact (0.125 in)	No Break		ASTM D4812
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	111		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	485	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	428	°F	ASTM D648
CLTE - Flow	4.4E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Surface Resistivity	10 to 1.0E+3	ohms	ASTM D257
Volume Resistivity	10 to 1.0E+3	ohms·cm	ASTM D257

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	510 to 530	°F
Middle Temperature	530 to 550	°F
Front Temperature	520 to 540	°F
Nozzle Temperature	520 to 540	°F
Processing (Melt) Temp	530 to 550	°F
Mold Temperature	175 to 220	°F
Injection Rate	Slow-Moderate	



---

Back Pressure

0.00 to 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.

---

**Notes**

---

<sup>1</sup> Typical properties: these are not to be construed as specifications.

