

**Electrafil® PA6/10 CF30 IM BK**

 Techmer Polymer Modifiers - *Polyamide 610*
**General Information**

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

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