

Edgetek™ NN-20CF/15T BK008

Polyamide 66
PolyOne Corporation

Message:
Carbon fiber reinforced and PTFE lubricated PA66 compounds

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 20% filler by weight		
Additive	PTFE lubricant		
Features	Lubrication		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.10 - 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	200	MPa	ASTM D638
Tensile Elongation ² (Break)	2.0	%	ASTM D638
Flexural Modulus ³	12500	MPa	ASTM D790
Flexural Strength ⁴	260	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	98	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	240	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2 - 1.0E+5	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	260 - 280	°C	
Middle Temperature	260 - 280	°C	
Front Temperature	260 - 280	°C	
Mold Temperature	65.0 - 85.0	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	5.0 mm/min		

2.	5.0 mm/min
3.	1.3 mm/min
4.	1.3 mm/min

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