

Tarnamid® T- 27 CF10

Polyamide 6

Grupa Azoty S.A.

Message:

It is 10% carbon fibre reinforced polyamide 6 compound, heat stabilised, good conductive and electrostatic properties.

General Information			
Filler / Reinforcement	Carbon Fiber,10% Filler by Weight		
Additive	Heat Stabilizer		
Features	Antistatic		
	Electrically Conductive		
	Heat Stabilized		
Uses	Mining Applications		
Appearance	Black		
	Natural Color		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.16	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	60.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	0.90	%	
Flow : 2.00 mm	0.30	%	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	200	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8000	MPa	ISO 527-2/1
Tensile Stress (Yield)	130	MPa	ISO 527-2/5
Tensile Strain (Break)	4.5	%	ISO 527-2/5
Flexural Modulus ¹	6700	MPa	ISO 178
Flexural Stress ²	195	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	3.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	42	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength	3.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	190	°C	ISO 75-2/A
Vicat Softening Temperature	200	°C	ISO 306/B

Melting Temperature	221	°C	ISO 11357-3
Limit of Temperature - a few hours operation	< 200	°C	
Temperature Index			
20000 hr	110	°C	
5000 hr	120	°C	
Burning Rate	+		FMVSS 302
ISO Type	PA6, MHRZ, 14-080, CF10		ISO 1874
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+8	ohms	IEC 60093
Volume Resistivity	1.0E+8	ohms·cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	HB		
3.20 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	< 80.0	°C	
Suggested Max Moisture	< 0.10	%	
Suggested Max Regrind	10	%	
Processing (Melt) Temp	240 to 260	°C	
Mold Temperature	60.0 to 80.0	°C	
Injection Pressure	80.0 to 110	MPa	
Injection Rate	Moderate		
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

