Clariant Nylon 6/6 PA-113CF30 TF15

Polyamide 66

Clariant Corporation

Message:

Clariant Nylon 6/6 PA-113CF30 TF15 is a polyamide 66 (nylon 66) material, which contains a 30% carbon fiber reinforced material. This product is available in North America and is processed by injection molding.
The main features of Clariant Nylon 6/6 PA-113CF30 TF15 are:
flame retardant/rated flame
Flame Retardant
Conductivity
high strength
Good processability
Typical application areas include:
Wire and cable
military applications
business/office supplies
Sporting goods
medical/health care

General Information	
Filler / Reinforcement	Carbon fiber reinforced material, 30% filler by weight
Additive	PTFE lubricant (15%) heat stabilizer
Features	Conductivity Low friction coefficient Rigidity, high High strength Workability, good Good corrosion resistance Good coloring Good chemical resistance Good wear resistance Thermal Stability Good toughness Lubrication Low or no water absorption Flame retardancy
Uses	Metal substitution Military application Business equipment Sporting goods Medical/nursing supplies

Agency Ratings	UL 94		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.38	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.25	%	ASTM D955
Water Absorption (24 hr)	0.45	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness			ASTM D785
Class m	93		ASTM D785
Class r	120		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	210	MPa	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	15900	MPa	ASTM D790
Flexural Strength	296	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	80	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	260	°C	ASTM D648
1.8 MPa, not annealed	257	°C	ASTM D648
CLTE - Flow	2.3E-5	cm/cm/°C	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+3	ohms·cm	ASTM D257
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature	79.4	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	266 - 293	°C	
Middle Temperature	266 - 293	°C	
Front Temperature	266 - 293	°C	
Processing (Melt) Temp	266 - 288	°C	
Melt Temperature (Aim)	274	°C	
Mold Temperature	65.6 - 93.3	°C	
Injection Rate	Fast		
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	20 - 100	rpm	
Cushion	3.18 - 6.35	mm	

Injection instructions

Injection Pressure: Use minimum pressure to achieve 95% fill during the boost inj. pressure phase.Hold Pressure: 30% to 75% of injection pressure.Mold Temp. Target: 180°FScrew Speed Target: 75 RPM

Recommended distributors for this material

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