

HiFill® PA6/12 CF30 BK

Polyamide 612

Techmer Engineered Solutions

Message:

HiFill® PA6/12 CF30 BK is a Polyamide 612 (Nylon 612) product filled with 30% carbon fiber. It can be processed by injection molding and is available in North America.

General Information			
Filler / Reinforcement	Carbon Fiber,30% Filler by Weight		
Appearance	Black		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.16	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	200	MPa	ASTM D638
Tensile Elongation (Break)	2.2	%	ASTM D638
Flexural Modulus	15900	MPa	ASTM D790
Flexural Strength	303	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	221	°C	
1.8 MPa, Unannealed	216	°C	
CLTE - Flow	2.0E-5	cm/cm/°C	ASTM D696
Additional Information	Nominal Value		
TPCI #	9814104		
Injection	Nominal Value	Unit	
Drying Temperature	73.9 to 104	°C	
Drying Time	2.0 to 16	hr	
Rear Temperature	271 to 282	°C	
Middle Temperature	277 to 288	°C	
Front Temperature	266 to 277	°C	

Nozzle Temperature	260 to 271	°C
Processing (Melt) Temp	271 to 282	°C
Mold Temperature	54.4 to 82.2	°C

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Recommended distributors for this material

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