

Chemlon® 60CF4

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

60CF4 is a 20% carbon fibre filled grade of nylon 6. It offers outstanding strength and stiffness - coupled with low density and improved electrical conductivity of moulded parts. It is suitable for applications such as bearings and mechanical parts

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 20% filler by weight		
Features	Low density		
	Rigidity, high		
	High strength		
Uses	Machine/mechanical parts		
	Bearing		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.22	g/cm ³	ISO 1183
Water Absorption (Equilibrium, 23°C, 50% RH)	2.4	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15000	MPa	ISO 527-2
Tensile Stress	200	MPa	ISO 527-2
Tensile Strain (Break)	4.0	%	ISO 527-2
Flexural Modulus	11000	MPa	ISO 178
Flexural Stress	230	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	6.0	kJ/m ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	> 200	°C	ISO 75-2/B
1.8 MPa, not annealed	> 200	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+12	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm, Teknor Apex test result)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	

Rear Temperature	250 - 270	°C
Middle Temperature	250 - 270	°C
Front Temperature	250 - 270	°C
Processing (Melt) Temp	250 - 280	°C
Mold Temperature	70.0 - 90.0	°C
Injection Rate	Fast	
Back Pressure	Low	
Screw Speed	Moderate	

Injection instructions

No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present.

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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

