

TECHNICAL DATA AND PROCESS SHEET

10% CARBON FIBER REINFORCED NYLON 6

INELEC PA6CF10

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.17		1.17	
SPECIFIC VOLUME		23.68	in ³ /lb	0.855	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	1.5	%	1.50	%
MOLD SHRINKAGE	D955	0.5-0.6	%	0.5-0.6	%
MECHANICAL					
TENSILE STRENGTH	D638	20,000	psi	138	MPa
ELONGATION, YIELD	D638	3-4	%	3-4	%
FLEXURAL STRENGTH	D790	31,000	psi	214	MPa
FLEXURAL MODULUS	D790	1,000,000	psi	6,895	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		0.8	ft.lb./in.	43	J/m
UNNOTCHED 1/8"		10	ft.lb./in.	533	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL @ 264 PSI	D648	390	°F	199	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.3	in./in. F x10 ⁻⁵	4.14	mm/mm C 10 ⁻⁶
FLAMMABILITY ¹	U.L.Subj 94	HB@1/16"	in	HB@ 1.5	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e ² -10e ⁶	ohms/sq	10e ² -10e ⁶	ohms/sq
PROCESSING					
DRYING TEMPERATURE		175	°F	79	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		480-550	°F	250 - 290	°C
MOLD TEMPERATURE		200	°F	93	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0005-0.001	in	0.0125 - 0.025	mm

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