HiFill® PA6/6 GF/M38 HS BK

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill® PA6/6 GF/M38 HS BK is a polyamide 66 (nylon 66) product, which contains 38% glass \minerals. It can be processed by injection molding and is available in North America. The main characteristics are: heat stabilizer.

General Information			
Filler / Reinforcement	Glass \mineral, 38% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.80	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	124	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	6620	MPa	ASTM D790
Flexural Strength	183	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	48	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	255	°C	ASTM D648
1.8 MPa, not annealed	235	°C	ASTM D648
CLTE - Flow	2.2E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+13	ohms·cm	ASTM D257
Dielectric Strength ¹	16	kV/mm	ASTM D149
Additional Information	Nominal Value		
TPCI #	9447101		
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	

Drying Time 2.0 - 4.0 hr Suggested Max Moisture 0.12 % Rear Temperature 282 - 293 °C Middle Temperature 288 - 299 °C Front Temperature 277 - 288 °C Nozzle Temperature 282 - 293 °C Processing (Melt) Temp 282 - 304 °C Mold Temperature 54.4 - 93.3 °C Injection Rate Moderate-Fast Back Pressure 0.345 - 0.689 MPa			
Rear Temperature 282 - 293 °C Middle Temperature 288 - 299 °C Front Temperature 277 - 288 °C Nozzle Temperature 282 - 293 °C Processing (Melt) Temp 282 - 304 °C Mold Temperature 54.4 - 93.3 °C Injection Rate Moderate-Fast	Drying Time	2.0 - 4.0	hr
Middle Temperature 288 - 299 °C Front Temperature 277 - 288 °C Nozzle Temperature 282 - 293 °C Processing (Melt) Temp 282 - 304 °C Mold Temperature 54.4 - 93.3 °C Injection Rate Moderate-Fast	Suggested Max Moisture	0.12	%
Front Temperature 277 - 288 °C Nozzle Temperature 282 - 293 °C Processing (Melt) Temp 282 - 304 °C Mold Temperature 54.4 - 93.3 °C Injection Rate Moderate-Fast	Rear Temperature	282 - 293	°C
Nozzle Temperature 282 - 293 °C Processing (Melt) Temp 282 - 304 °C Mold Temperature 54.4 - 93.3 °C Injection Rate Moderate-Fast	Middle Temperature	288 - 299	°C
Processing (Melt) Temp 282 - 304 °C Mold Temperature 54.4 - 93.3 °C Injection Rate Moderate-Fast	Front Temperature	277 - 288	°C
Mold Temperature 54.4 - 93.3 °C Injection Rate Moderate-Fast	Nozzle Temperature	282 - 293	°C
Injection Rate Moderate-Fast	Processing (Melt) Temp	282 - 304	°C
J	Mold Temperature	54.4 - 93.3	°C
Back Pressure 0.345 - 0.689 MPa	Injection Rate	Moderate-Fast	
	Back Pressure	0.345 - 0.689	MPa

Injection instructions

Screw Speed: MediumRecommendations for Molding and Tool Conditions: Well ventedMoisture Content, as received: Product is packaged at 0.2% or less.Recomended Max Moisture: 0.12% down to 0.08%

NOTE

1.

Method A (short time)

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