

HiFill FR® PA6/6 GF25 FR-N IM

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill FR® PA6/6 GF25 FR-N IM is a Polyamide 66 (Nylon 66) product filled with 25% glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

- Flame Rated
- Flame Retardant
- Impact Modified
- Impact Resistant

General Information			
UL YellowCard	E253782-101773886		
Filler / Reinforcement	Glass Fiber,25% Filler by Weight		
Additive	Impact Modifier		
Features	Flame Retardant		
	High Impact Resistance		
UL File Number	E157318		
Appearance	Colors Available		
	Natural Color		
	Red		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	85		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	99.3	MPa	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Flexural Modulus	5520	MPa	ASTM D790
Flexural Strength	131	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	120	J/m	
23°C	220	J/m	
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed)	229	°C	ASTM D648
CLTE - Flow	3.6E-5	cm/cm/°C	ASTM D696
RTI Elec	120	°C	UL 746
RTI Imp	120	°C	UL 746
RTI Str	120	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	ASTM D257
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength ¹	20	kV/mm	ASTM D149
Comparative Tracking Index (CTI)	550	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	V-0		
2.00 mm	5VA		
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	> 6.0	hr	
Rear Temperature	254 to 277	°C	
Middle Temperature	254 to 277	°C	
Front Temperature	254 to 277	°C	
Processing (Melt) Temp	249 to 271	°C	
Mold Temperature	65.6 to 93.3	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	30 to 60	rpm	
NOTE			

1. Method A (Short-Time)

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Recommended distributors for this material

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

