

HiFill FR® PA6/6 GF13 FR BK

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill FR® PA6/6 GF13 FR BK is a Polyamide 66 (Nylon 66) product filled with 13% glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

Flame Retardant

Heat Stabilizer

Lubricated

General Information			
Filler / Reinforcement	Glass Fiber,13% Filler by Weight		
Additive	Heat Stabilizer Lubricant		
Features	Flame Retardant Heat Stabilized Lubricated		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.44	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.75	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	111		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	95.1	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	4960	MPa	ASTM D790
Flexural Strength	152	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	224	°C	ASTM D648
CLTE - Flow	5.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method

Surface Resistivity	1.0E+11	ohms	ASTM D257
Volume Resistivity	1.0E+9	ohms·cm	ASTM D257
Dielectric Strength ¹	19	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Additional Information	Nominal Value		
TPCI #	8152101		
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



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