HiFill® PA6 GF33 IM L

Polyamide 6

Techmer Engineered Solutions

Message:

HiFill®PA6 GF33 IM L is a polyamide 6 (nylon 6) product that contains a glass fiber reinforced material. It can be processed by injection molding and is available in North America.
Features include:
flame retardant/rated flame
Impact modification
Impact resistance
Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Additive	Impact modifier Lubricant		
Features	Impact resistance, high Lubrication		
UL File Number	E157318		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.41	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	3.5	%	ASTM D955
Water Absorption (24 hr)	0.50	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	155	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	6890	MPa	ASTM D790
Flexural Strength	207	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ASTM D256
-40°C, 3.18 mm	100	J/m	ASTM D256
23°C, 3.18 mm	170	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	1400	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**

Deflection Temperature Under Load (1.8 MPa, Unannealed)	213	°C	ASTM D648
CLTE - Flow	3.6E-5	cm/cm/°C	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	2.0E+13	ohms·cm	ASTM D257
Dielectric Strength [1]	15	kV/mm	ASTM D149
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	HB		UL 94
Additional Information	**Nominal Value**		
TPCI #	6150102		
Injection	**Nominal Value**	**Unit**	
Drying Temperature	82.2	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	266 - 277	°C	
Middle Temperature	277 - 288	°C	
Front Temperature	271 - 282	°C	
Nozzle Temperature	271 - 282	°C	
Processing (Melt) Temp	277 - 288	°C	
Mold Temperature	79.4 - 104	°C	
Injection Rate	Slow-Moderate		
Back Pressure	0.00 - 0.345	MPa	

Injection instructions

Screw Speed: MediumRecommendations for Molding and Tool Conditions: Well vented moldMoisture Content, as received: Product is packaged at 0.2% or less.

NOTE

1. Method A (short time)

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

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Phone: +86 13424755533

Email: sales@su-jiao.com

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