

HiFill FR® PA6/6 GF35 FR-N BK

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill FR® PA6/6 GF35 FR-N BK is a Polyamide 66 (Nylon 66) product filled with 35% glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

Flame Retardant

Halogen Free

General Information			
UL YellowCard	E253782-101773892		
Filler / Reinforcement	Glass Fiber,35% Filler by Weight		
Features	Flame Retardant		
	Halogen Free		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.46	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.40	%	ASTM D955
Water Absorption (24 hr)	0.58	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	162	MPa	ASTM D638
Tensile Elongation (Break)	2.2	%	ASTM D638
Flexural Modulus	9650	MPa	ASTM D790
Flexural Strength	228	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	96	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	254	°C	
1.8 MPa, Unannealed	252	°C	
CLTE - Flow	2.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms · cm	ASTM D257
Dielectric Strength ¹	2.0	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method

Flame Rating (0.800 mm)	V-0	UL 94
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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