

HiFill® PA4/6 GF25 HS NAT

Polyamide 46
Techmer Engineered Solutions

Message:

HiFill® PA4/6 GF25 HS NAT is a Polyamide 46 (Nylon 46) product filled with 25% glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated
Heat Stabilizer

General Information				
Filler / Reinforcement		Glass Fiber,25% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Appearance		Colors Available		
		Natural Color		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.37	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.70	--	%	ASTM D955
Water Absorption (24 hr)	1.5	--	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Break)	186	110	MPa	ASTM D638
Tensile Elongation (Break)	4.0	7.0	%	ASTM D638
Flexural Modulus	8270	5170	MPa	ASTM D790
Flexural Strength	221	179	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	96	150	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	291	--	°C	ASTM D648
Melting Temperature	295	--	°C	
CLTE - Flow	1.8E-5	--	cm/cm/°C	ASTM D696
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+14	--	ohms · cm	ASTM D257
Dielectric Strength ¹	24	--	kV/mm	ASTM D149
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.50 mm)	HB	--		UL 94

Injection	Dry	Unit
Drying Temperature	85.0	°C
Drying Time	4.0 to 8.0	hr
Rear Temperature	282 to 316	°C
Middle Temperature	282 to 316	°C
Front Temperature	282 to 316	°C
Processing (Melt) Temp	246 to 316	°C
Mold Temperature	87.8 to 127	°C
Back Pressure	0.00 to 0.345	MPa
Screw Speed	40 to 80	rpm
NOTE		

1. Method A (Short-Time)

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