

HiFill® PA6/6 LGF60 HS L UV 12mm

Polyamide 66
Techmer Engineered Solutions

Message:

HiFill®PA6/6 LGF60 HS L UV 12mm is a polyamide 66 (nylon 66) product containing long glass fibers. It can be processed by injection molding and is available in North America.

Features include:

- heat stabilizer
- Lubrication
- UV stability

General Information			
Filler / Reinforcement	Long glass fiber		
Additive	heat stabilizer		
	Lubricant		
	UV stabilizer		
Features	Thermal Stability		
	Lubrication		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.70	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20	%	ASTM D955
Water Absorption (24 hr)	0.35	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	248	MPa	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	21400	MPa	ASTM D790
Flexural Strength	365	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	230	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	No Break		ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	257	°C	ASTM D648
CLTE - Flow	2.3E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method

1.0E+11

Surface Resistivity	1.0E+9	ohms	ASTM D257
Dielectric Strength ¹	20	kV/mm	ASTM D149

Injection	Nominal Value	Unit
Drying Temperature	82.2	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.12	%
Rear Temperature	282 - 293	°C
Middle Temperature	288 - 299	°C
Front Temperature	277 - 288	°C
Nozzle Temperature	282 - 293	°C
Processing (Melt) Temp	282 - 304	°C
Mold Temperature	54.4 - 93.3	°C
Injection Rate	Moderate-Fast	
Back Pressure	0.345 - 0.689	MPa

Injection instructions

Screw Speed: SlowRecommendations for Molding and Tool Conditions: Well ventedMoisture Content, as received: Product is packaged at 0.2% or less.Recomended Max Moisture: 0.12% down to 0.08%

NOTE

1. Method A (short time)

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