

# HiFill® PA4/6 GF33 HS NAT

Polyamide 46

Techmer Engineered Solutions

## Message:

HiFill® PA4/6 GF33 HS NAT is a Polyamide 46 (Nylon 46) product filled with 33% 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,33% 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	1.43	--	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	--	%	ASTM D955
Water Absorption (24 hr)	1.5	--	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Break)	207	117	MPa	ASTM D638
Tensile Elongation (Break)	4.0	7.0	%	ASTM D638
Flexural Modulus	8960	5380	MPa	ASTM D790
Flexural Strength	255	186	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 <sup>1</sup>	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)

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

**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

