

# HiFill® PA6/6 GF/M35 HS BK

Polyamide 66  
Techmer Engineered Solutions

Message:

HiFill®PA6/6 GF/M35 HS BK is a polyamide 66 (nylon 66) product, which contains 35% glass \minerals. It can be processed by injection molding and is available in North America.

Features include:

heat stabilizer

Lubrication

General Information			
Filler / Reinforcement	Glass \mineral, 35% filler by weight		
Additive	heat stabilizer		
	Lubricant		
Features	Thermal Stability		
	Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	114	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	6890	MPa	ASTM D790
Flexural Strength	159	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	530	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	253	°C	ASTM D648
1.8 MPa, not annealed	202	°C	ASTM D648
CLTE - Flow	1.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method

Volume Resistivity	1.0E+13	ohms·cm	ASTM D257
Dielectric Strength <sup>1</sup>	16	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: MediumRecommendations 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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