

HiFill FR® PA6/6 GF50 FR BK

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill FR® PA6/6 GF50 FR BK is a Polyamide 66 (Nylon 66) product filled with 50% glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

Flame Retardant

| General Information | | | |
|---|----------------------------------|-------------------|-------------|
| Filler / Reinforcement | Glass Fiber,50% Filler by Weight | | |
| Features | Flame Retardant | | |
| Appearance | Black | | |
| Forms | Pellets | | |
| Processing Method | Injection Molding | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 1.69 | 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) | 200 | MPa | ASTM D638 |
| Tensile Elongation (Break) | 2.0 | % | ASTM D638 |
| Flexural Modulus | 16500 | MPa | ASTM D790 |
| Flexural Strength | 296 | MPa | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (23°C, 3.18 mm) | 100 | J/m | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load (1.8 MPa, Unannealed) | 260 | °C | ASTM D648 |
| CLTE - Flow | 1.6E-5 | cm/cm/°C | ASTM D696 |
| Electrical | Nominal Value | Unit | Test Method |
| Volume Resistivity | 1.0E+16 | 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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