

HiFill FR® PA6/6 FR 344

Polyamide 66
Techmer Engineered Solutions

Message:

HiFill FR® PA6/6 FR 344 is a Polyamide 66 (Nylon 66) product. It can be processed by injection molding and is available in North America. Characteristics include:
Flame Rated
Flame Retardant
Heat Stabilizer
Lubricated

General Information			
UL YellowCard	E253782-101773883		
Additive	Heat Stabilizer		
	Lubricant		
Features	Flame Retardant		
	Heat Stabilized		
	Lubricated		
Appearance	Colors Available		
	Red		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.8	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	55.8	MPa	ASTM D638
Tensile Elongation (Yield)	70	%	ASTM D638
Flexural Modulus	2760	MPa	ASTM D790
Flexural Strength	88.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	216	°C	
1.8 MPa, Unannealed	71.1	°C	

CLTE - Flow	7.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength ¹	27	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.800 mm	V-0		
3.00 mm	5VA		
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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