

HiFill® PA6/6 G/CF20 IM HS BK

Polyamide 66
Techmer Engineered Solutions

Message:

HiFill® PA6/6G/CF20 IM HS BK is a polyamide 66 (nylon 66) product, which contains 20% glass and carbon fiber reinforced materials. It can be processed by injection molding and is available in North America.

Features include:

- heat stabilizer
- Lubrication

| General Information | | | |
|-------------------------------------|---|-------------------|-------------|
| Filler / Reinforcement | Glass and carbon fiber reinforced materials, 20% 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 | 1.21 | g/cm ³ | ASTM D792 |
| Molding Shrinkage - Flow (3.18 mm) | 0.50 | % | ASTM D955 |
| Water Absorption (24 hr) | 1.0 | % | ASTM D570 |
| Hardness | Nominal Value | Unit | Test Method |
| Rockwell Hardness (R-Scale) | 115 | | ASTM D785 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Strength (Break) | 131 | MPa | ASTM D638 |
| Tensile Elongation (Break) | 2.5 | % | ASTM D638 |
| Flexural Modulus | 8270 | MPa | ASTM D790 |
| Flexural Strength | 179 | MPa | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (23°C, 3.18 mm) | 110 | J/m | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load | | | ASTM D648 |
| 0.45 MPa, not annealed | 254 | °C | ASTM D648 |
| 1.8 MPa, not annealed | 243 | °C | ASTM D648 |
| CLTE - Flow | 2.0E-5 | cm/cm/°C | ASTM D696 |
| Electrical | Nominal Value | Unit | Test Method |
| Surface Resistivity | 1.0E+4 - 1.0E+7 | ohms | ASTM D257 |

| | | | |
|------------------------|-----------------|-----------|-----------|
| Volume Resistivity | 1.0E+4 - 1.0E+7 | ohms · cm | ASTM D257 |
| 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: Medium Recommendations for Molding and Tool Conditions: Well vented Moisture Content, as received: Product is packaged at 0.2% or less. Recommended Max Moisture: 0.12% down to 0.08%

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