

# HiFill® PA4/6 CF30

Polyamide 46

Techmer Engineered Solutions

## Message:

HiFill® PA4/6 CF30 is a Polyamide 46 (Nylon 46) product filled with 30% carbon fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

Heat Stabilizer

General Information				
Filler / Reinforcement		Carbon Fiber,30% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Appearance		Black		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.31	--	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20	--	%	ASTM D955
Water Absorption (24 hr)	1.9	--	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Break)	228	179	MPa	ASTM D638
Tensile Elongation (Break)	1.5	3.5	%	ASTM D638
Flexural Modulus	16500	11000	MPa	ASTM D790
Flexural Strength	365	283	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	80	110	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	285	--	°C	ASTM D648
CLTE - Flow	2.0E-5	--	cm/cm/°C	ASTM D696
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	10	--	ohms · cm	ASTM D257
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

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Recommended distributors for this material

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