

HiFill® PA6 GF50 L LE

Polyamide 6

Techmer Engineered Solutions

Message:

HiFill® PA6 GF50 L LE is a Polyamide 6 (Nylon 6) product filled with 50% glass fiber. It can be processed by injection molding and is available in North America. Typical application: Food Contact Applications. Primary characteristic: lubricated.

General Information			
Filler / Reinforcement	Glass Fiber,50% Filler by Weight		
Additive	Lubricant		
Features	Low Extractables		
	Lubricated		
Agency Ratings	FDA Unspecified Rating		
Appearance	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.57	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.75	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	221	MPa	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	14100	MPa	ASTM D790
Flexural Strength	290	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	160	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	1100	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	218	°C	
1.8 MPa, Unannealed	216	°C	
CLTE - Flow	1.4E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257

Dielectric Strength ¹	18	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	260 to 304	°C	
Middle Temperature	260 to 304	°C	
Front Temperature	260 to 304	°C	
Processing (Melt) Temp	243 to 271	°C	
Mold Temperature	65.6 to 93.3	°C	
Back Pressure	0.00 to 0.345	MPa	
Screw Speed	30 to 60	rpm	

NOTE

1. Method A (Short-Time)

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