

# HiFill® PA4/6 GF45 HS BK

Polyamide 46

Techmer Engineered Solutions

## Message:

HiFill® PA4/6 GF45 HS BK is a Polyamide 46 (Nylon 46) product filled with 45% glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

Heat Stabilizer

General Information			
Filler / Reinforcement	Glass Fiber,45% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.57	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	231	MPa	ASTM D638
Tensile Elongation (Break)	2.8	%	ASTM D638
Flexural Modulus	11000	MPa	ASTM D790
Flexural Strength	317	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	288	°C	ASTM D648
CLTE - Flow	3.4E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	8.0E+15	ohms · cm	ASTM D257
Dielectric Strength <sup>1</sup>	22	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value		
TPCI #	9627150		
Injection	Nominal Value	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

NOTE

1. Method A (Short-Time)

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Recommended distributors for this material

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