

# HiFill® PA6/6 GF25 FR-NR IM BK

Polyamide 66  
Techmer Engineered Solutions

Message:

HiFill®PA6/6 GF25 FR-NR IM BK is a polyamide 66 (nylon 66) product, which contains a glass fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

- flame retardant/rated flame
- Flame Retardant
- Impact modification
- Halogen-free

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Additive	Impact modifier		
	Flame retardancy		
Features	Impact modification		
	Halogen-free		
	Flame retardancy		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	75.8	MPa	ASTM D638
Fracture	88.3	MPa	ASTM D638
Tensile Elongation (Break)	5.5	%	ASTM D638
Flexural Modulus	5520	MPa	ASTM D790
Flexural Strength	117	MPa	ASTM D790
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	229	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	ASTM D257
Volume Resistivity	1.0E+13	ohms · cm	ASTM D257

Dielectric Strength <sup>1</sup>	20	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.18 mm)	V-0		UL 94
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: MediumRecommendations for Molding and Tool Conditions: Well ventedMoisture Content, as received: Product is packaged at 0.2% or less.Recomended Max Moisture: 0.12% down to 0.08%			
NOTE			
1.	Method A (short time)		

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection.All rights belong to the original authors. If any infringement occurs, please contact us immediately.

#### Recommended distributors for this material

### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

