

HiFill FR® PA6/6 GF25 FR BK

Polyamide 66
Techmer Engineered Solutions

Message:

HiFill FR® PA6/6 GF25 FR BK is a Polyamide 66 (Nylon 66) product filled with 25% glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated
Flame Retardant
Heat Stabilizer
Lubricated

General Information				
Filler / Reinforcement		Glass Fiber,25% Filler by Weight		
Additive		Heat Stabilizer		
		Lubricant		
Features		Flame Retardant		
		Heat Stabilized		
		Lubricated		
Appearance		Black		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.51	1.51	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	0.30	%	ASTM D955
Water Absorption (24 hr)	0.60	0.60	%	ASTM D570
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	120	120		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Break)	134	120	MPa	ASTM D638
Tensile Elongation (Break)	4.0	4.0	%	ASTM D638
Flexural Modulus	7240	6550	MPa	ASTM D790
Flexural Strength	186	172	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	100	120	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	253	--	°C	ASTM D648

CLTE - Flow	3.6E-5	--	cm/cm/°C	ASTM D696
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+13	--	ohms	ASTM D257
Volume Resistivity	1.0E+15	--	ohms·cm	ASTM D257
Dielectric Strength ¹	17	--	kV/mm	ASTM D149
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.50 mm, NC, BK, Colors)	V-0	--		UL 94
Additional Information	Dry	Conditioned		
TPCI #	8230101	--		
Injection	Dry	Unit		
Drying Temperature	82.2		°C	
Drying Time	> 6.0		hr	
Rear Temperature	254 to 277		°C	
Middle Temperature	254 to 277		°C	
Front Temperature	254 to 277		°C	
Processing (Melt) Temp	249 to 271		°C	
Mold Temperature	65.6 to 93.3		°C	
Back Pressure	0.345 to 0.689		MPa	
Screw Speed	30 to 60		rpm	
NOTE				
1.	Method A (Short-Time)			

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