

HiFill® PA6 GF15 L

Polyamide 6
Techmer Engineered Solutions

Message:

HiFill® PA6 GF15 L is a Polyamide 6 (Nylon 6) product filled with 15% glass fiber. It can be processed by injection molding and is available in North America.
Characteristics include:
Flame Rated
Lubricated

General Information			
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
Additive	Lubricant		
Features	Lubricated		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	1.4	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	110	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	3100	MPa	ASTM D790
Flexural Strength	153	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	213	°C	
1.8 MPa, Unannealed	196	°C	
CLTE - Flow	4.3E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength ¹	20	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
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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Recommended distributors for this material

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