

HiFill® PA6/6 GF35 L UV

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill® PA6/6 GF35 L UV is a polyamide 66 (nylon 66) product, which contains a 35% glass fiber reinforced material. It can be processed by injection molding and is available in North America.

- Features include:
- flame retardant/rated flame
 - Good UV resistance
 - heat stabilizer
 - Lubrication
 - UV stability

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 35% filler by weight		
Additive		heat stabilizer		
		Lubricant		
		UV stabilizer		
Features		Good UV resistance		
		Thermal Stability		
		Lubrication		
Appearance		Available colors		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.41	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.40	--	%	ASTM D955
Water Absorption (24 hr)	0.50	--	%	ASTM D570
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	121	121		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Break)	206	158	MPa	ASTM D638
Tensile Elongation (Break)	3.0	5.0	%	ASTM D638
Flexural Modulus	8960	7580	MPa	ASTM D790
Flexural Strength	288	240	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	130	150	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	1000	1000	J/m	ASTM D256

Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, not annealed	260	--	°C	ASTM D648
1.8 MPa, not annealed	254	--	°C	ASTM D648
Melting Temperature	262	--	°C	
CLTE - Flow	3.2E-5	--	cm/cm/°C	ASTM D696
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+14	--	ohms·cm	ASTM D257
Dielectric Strength ¹	18	--	kV/mm	ASTM D149
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating	HB	--		UL 94
Injection	Dry	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)

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