

HiFill® PPA GF33 FR HS L

Polyphthalamide
Techmer Engineered Solutions

Message:

HiFill® PPA GF33 FR HS L is a Polyphthalamide (PPA) product filled with 33% 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,33% Filler by Weight		
Additive	Heat Stabilizer Lubricant		
Features	Flame Retardant Heat Stabilized Lubricated		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.68	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.18	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	165	MPa	ASTM D638
Tensile Elongation (Break)	1.8	%	ASTM D638
Flexural Modulus	12400	MPa	ASTM D790
Flexural Strength	228	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 (1.8 MPa, Unannealed)	299	°C	ASTM D648
CLTE - Flow	5.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength ¹	21	kV/mm	ASTM D149

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.59 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	104	°C	
Drying Time	4.0 to 8.0	hr	
Rear Temperature	327 to 360	°C	
Middle Temperature	327 to 360	°C	
Front Temperature	327 to 360	°C	
Processing (Melt) Temp	316 to 338	°C	
Mold Temperature	93.3 to 149	°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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