HiFill® PA6/6 GB10 L

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill®PA6/6 GB10 L is a polyamide 66 (nylon 66) product containing 10% glass beads. It can be processed by injection molding and is available in North America. Features include: flame retardant/rated flame Lubrication

Filler / Reinforcement Glass beaks, 10% filler by weight Additive Lubricant Features Lubrication Apparance Available colors Forms Particle Processing Method Injection molding Physica Nominal Value Unit Specific Gravity 1.24 g/cm ³ Molding Shrinkage - Flow (3.18 mm) 1.8 % Mater Absorption (24 hr) 0.90 % Mater Absorption (24 hr) 0.90 % Methardness Nominal Value Unit Rockwell Hardness (R-Scale) 119 ASTM D785 Methardness Nominal Value Unit Test Method Tensile Elongation (Break) 3.5 % ASTM D638 Flexural Modulus 2760 MPa ASTM D790 Impact Nominal Value Unit Test Method Integrad Nominal Value Unit Test Method Impact Nominal Value Unit Test Method Impact Nominal Value Unit Test Method Integrad Stom D790 MPa ASTM D530 Impact Nominal Value Unit Test Method Nortical Lood Impact (32, S. Br) <td< th=""><th>General Information</th><th></th><th></th><th></th></td<>	General Information			
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Flexural Strength117MPaASTM D790ImpactNominal ValueUnitTest MethodNotched Izod Impact (23°C, 3.18 mm)32J/mASTM D256Unnotched Izod Impact (3.18 mm)200J/mASTM D256ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load232°CASTM D6481.8 MPa, not annealed160°CASTM D648Melting Temperature595-5cm/cm/°CASTM D648ElectricalNominal ValueUnitTest MethodVolume Resistivity1.0E+14ohms·cmASTM D57	Tensile Elongation (Break)	3.5	%	ASTM D638
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Electrical Nominal Value Unit Test Method Volume Resistivity 1.0E+14 ohms·cm ASTM D257	Melting Temperature	255	°C	
Volume Resistivity 1.0E+14 ohms · cm ASTM D257	CLTE - Flow	5.9E-5	cm/cm/°C	ASTM D696
	Electrical	Nominal Value	Unit	Test Method
	Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength ¹ 16 kV/mm ASTM D149	Dielectric Strength ¹	16	kV/mm	ASTM D149
Flammability Nominal Value Unit Test Method	Flammability	Nominal Value	Unit	Test Method

Flame Rating (1.50 mm)	НВ		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)

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