

# HiFill® PA6/6 G/CF30 L BK

Polyamide 66  
Techmer Engineered Solutions

Message:

HiFill® PA6/6G/CF30 L BK is a polyamide 66 (nylon 66) product, which contains 30% glass and carbon fiber reinforced materials. It can be processed by injection molding and is available in North America.

Features include:

- heat stabilizer
- Lubrication

General Information			
Filler / Reinforcement	Glass and carbon fiber reinforced materials, 30% filler by weight		
Additive	heat stabilizer		
	Lubricant		
Features	Thermal Stability		
	Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.40	%	ASTM D955
Water Absorption (24 hr)	1.8	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	159	MPa	ASTM D638
Yield, 23°C	159	MPa	ASTM D638
Fracture, 23°C	185	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	5.5	%	ASTM D638
	6070		
Flexural Modulus	6890	MPa	ASTM D790
	198		
Flexural Strength	214	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
	67		
Notched Izod Impact	75	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	255	°C	ASTM D648
1.8 MPa, not annealed	250	°C	ASTM D648
CLTE - Flow	2.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+4 - 1.0E+5	ohms	ASTM D257
Volume Resistivity	1.0E+4 - 1.0E+5	ohms·cm	ASTM D257
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: Medium Recommendations for Molding and Tool Conditions: Well vented Moisture Content, as received: Product is packaged at 0.2% or less. Recommended Max Moisture: 0.12% down to 0.08%

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#### Recommended distributors for this material

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