

HiFill® PA6 LGF35 HS L 12mm

Polyamide 6
Techmer Engineered Solutions

Message:

HiFill® PA6 LGF35 HS L 12mm is a Polyamide 6 (Nylon 6) product filled with 35% glass fiber. It can be processed by injection molding and is available in North America.
Characteristics include:
Flame Rated
Heat Stabilizer
Lubricated

General Information			
Filler / Reinforcement	Glass Fiber,35% Filler by Weight		
Additive	Heat Stabilizer Lubricant		
Features	Heat Stabilized Lubricated		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	3.5	%	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	152	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	8270	MPa	ASTM D790
Flexural Strength	234	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.18 mm	100	J/m	
23°C, 3.18 mm	210	J/m	
Unnotched Izod Impact (3.18 mm)	1400	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	210	°C	ASTM D648
CLTE - Flow	3.6E-5	cm/cm/°C	ASTM D696

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	2.0E+13	ohms·cm	ASTM D257
Dielectric Strength ¹	15	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	2.0 to 4.0	hr	
Rear Temperature	232 to 257	°C	
Middle Temperature	232 to 257	°C	
Front Temperature	232 to 257	°C	
Processing (Melt) Temp	238 to 266	°C	
Mold Temperature	65.6 to 93.3	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	30 to 60	rpm	
NOTE			

1. Method A (Short-Time)

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