

HiFill FR® PA6/6 GF33 FR HS L

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill FR® PA6/6 GF33 FR HS L is a Polyamide 66 (Nylon 66) 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)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	162	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	10700	MPa	ASTM D790
Flexural Strength	228	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	250	°C	ASTM D648
CLTE - Flow	3.4E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method

Surface Resistivity	1.0E+12	ohms	ASTM D257
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength ¹	18	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	> 6.0	hr	
Rear Temperature	254 to 277	°C	
Middle Temperature	254 to 277	°C	
Front Temperature	254 to 277	°C	
Processing (Melt) Temp	249 to 271	°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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