

HiFill FR® PA6/6 CF15 FR BK

Polyamide 66
Techmer Engineered Solutions

Message:

HiFill FR® PA6/6 CF15 FR BK is a Polyamide 66 (Nylon 66) product filled with 15% carbon fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated
Flame Retardant
Lubricated

General Information			
Filler / Reinforcement	Carbon Fiber, 15% Filler by Weight		
Additive	Lubricant		
Features	Flame Retardant		
	Lubricated		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.47	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20	%	ASTM D955
Water Absorption (24 hr)	0.50	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	152	MPa	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	10700	MPa	ASTM D790
Flexural Strength	262	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)	252	°C	ASTM D648
CLTE - Flow	2.3E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2 to 1.0E+4	ohms	ASTM D257
Volume Resistivity	1.0E+2 to 1.0E+4	ohms · cm	ASTM D257
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

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Recommended distributors for this material

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