

HiFill® PA6/6 GF4 IM L LE

Polyamide 66
Techmer Engineered Solutions

Message:

HiFill® PA6/6 GF4 IM L LE is a polyamide 66 (nylon 66) product. It can be processed by injection molding and is available in North America. Typical application areas are: food contact applications.
Features include:
flame retardant/rated flame
Impact modification
Impact resistance
Lubrication

General Information			
Additive	Impact modifier		
	Lubricant		
Features	Low extract		
	Impact resistance, high		
	Lubrication		
Agency Ratings	FDA not rated		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.2	%	ASTM D955
Water Absorption (24 hr)	1.3	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	50.3	MPa	ASTM D638
Tensile Elongation (Break)	30	%	ASTM D638
Flexural Modulus	1760	MPa	ASTM D790
Flexural Strength	79.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.18 mm	180	J/m	ASTM D256
23°C, 3.18 mm	530	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	No Break		ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	216	°C	ASTM D648
1.8 MPa, not annealed	71.1	°C	ASTM D648
CLTE - Flow	7.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	2.0E+14	ohms·cm	ASTM D257
Dielectric Strength ¹	17	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	282 - 293	°C	
Middle Temperature	288 - 299	°C	
Front Temperature	277 - 288	°C	
Nozzle Temperature	271 - 304	°C	
Processing (Melt) Temp	282 - 304	°C	
Mold Temperature	79.4 - 104	°C	
Injection Rate	Slow-Moderate		
Back Pressure	0.00 - 0.345	MPa	
Injection instructions			
Screw Speed: SlowRecommendations for Molding and Tool Conditions: Well vented moldMoisture Content, as received: Product is packaged at 0.2% or less.			
NOTE			

1. Method A (short time)

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