

HiFill® PA6/6 GF43 IM HS L BK001

Polyamide 66
Techmer Engineered Solutions

Message:

HiFill® PA6/6 GF43 IM HS L BK001 is a polyamide 66 (nylon 66) product, which contains 20% glass fiber reinforced materials and 10% glass beads. It can be processed by injection molding and is available in North America.

Features include:

- flame retardant/rated flame
- heat stabilizer
- Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
	Glass beads, 10% filler by weight		
Additive	heat stabilizer		
	Lubricant		
Features	Thermal Stability		
	Lubrication		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow: 3.18mm	0.50	%	ASTM D955
Transverse flow	0.60	%	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	111		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	159	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	8960	MPa	ASTM D790
Flexural Strength	213	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	160	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	260	°C	ASTM D648

1.8 MPa, not annealed	252	°C	ASTM D648
CLTE - Flow	7.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	ASTM D257
Volume Resistivity	1.0E+11	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	0.12	%	
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: MediumRecommendations for Molding and Tool Conditions: Well ventedMoisture Content, as received: Product is packaged at 0.2% or less.Recomended Max Moisture: 0.12% down to 0.08%			
NOTE			

- Method A (short time)

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