

# HiFill® PA6/6 GF/M40 HS L NAT

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill®PA6/6 GF/M40 HS L NAT is a polyamide 66 (nylon 66) product containing 40% glass \mineral. It can be processed by injection molding and is available in North America.

Features include:

heat stabilizer

Lubrication

General Information			
Filler / Reinforcement	Glass \mineral, 40% filler by weight		
Additive	heat stabilizer		
	Lubricant		
Features	Thermal Stability		
	Lubrication		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.40	%	ASTM D955
Water Absorption (24 hr)	0.50	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	116	MPa	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	6890	MPa	ASTM D790
Flexural Strength	152	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	48	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	530	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	252	°C	ASTM D648
1.8 MPa, not annealed	229	°C	ASTM D648

CLTE - Flow	1.6E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	8.0E+14	ohms·cm	ASTM D257
Dielectric Strength <sup>1</sup>	18	kV/mm	ASTM D149
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			
1.	Method A (short time)		

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