

HiFill® PA6/6 GF10 IM L BK

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill® PA6/6 GF10 IM L BK is a polyamide 66 (nylon 66) product, which contains a 10% glass fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Additive	Lubricant		
Features	Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.16	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	74.5	MPa	ASTM D638
Tensile Elongation (Break)	5.5	%	ASTM D638
Flexural Modulus	3240	MPa	ASTM D790
Flexural Strength	110	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	150	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	232	°C	ASTM D648
CLTE - Flow	5.4E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.0E+14	ohms · cm	ASTM D257
Dielectric Strength ¹	19	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	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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