

# HiFill® PA6 GF43 LE

Polyamide 6

Techmer Engineered Solutions

## Message:

HiFill® PA6 GF43 LE is a Polyamide 6 (Nylon 6) product filled with 43% glass fiber. It can be processed by injection molding and is available in North America. Applications of HiFill® PA6 GF43 LE include food contact applications and plumbing/piping/potable water.

Characteristics include:

Heat Stabilizer

Lubricated

General Information			
Filler / Reinforcement	Glass Fiber,43% Filler by Weight		
Additive	Heat Stabilizer		
	Lubricant		
Features	Heat Stabilized		
	Low Extractables		
	Lubricated		
Agency Ratings	FDA Unspecified Rating		
	NSF Unspecified Rating		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.50	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	200	MPa	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	10300	MPa	ASTM D790
Flexural Strength	248	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	120	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	1100	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	216	°C	
1.8 MPa, Unannealed	210	°C	
CLTE - Flow	1.6E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength <sup>1</sup>	18	kV/mm	ASTM D149
Additional Information	Nominal Value		
TPCI #	9571102		
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	260 to 304	°C	
Middle Temperature	260 to 304	°C	
Front Temperature	260 to 304	°C	
Processing (Melt) Temp	243 to 271	°C	
Mold Temperature	65.6 to 93.3	°C	
Back Pressure	0.00 to 0.345	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	Method A (Short-Time)		

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#### Recommended distributors for this material

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