

# HiFill® PA6 GF/M15 A1 BK

Polyamide 6  
Techmer Engineered Solutions

Message:

HiFill® PA6 GF/M15 A1 BK is a Polyamide 6 (Nylon 6) product filled with 15% glass\mineral. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated  
Heat Stabilizer

General Information			
Filler / Reinforcement	Glass\Mineral, 15% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.5	%	ASTM D955
Water Absorption (24 hr)	0.85	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	75.8	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	2830	MPa	ASTM D790
Flexural Strength	117	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	199	°C	
1.8 MPa, Unannealed	132	°C	
Melting Temperature	216	°C	
CLTE - Flow	5.2E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.0E+14	ohms · cm	ASTM D257
Dielectric Strength <sup>1</sup>	20	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	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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