

HiFill® PPA GF35 HS LAHW BK MB

Polyphthalamide

Techmer Engineered Solutions

Message:

High Temperature Nylon

General Information			
Filler / Reinforcement	Glass Fiber,35% Filler by Weight		
Features	Heat Stabilized		
	Hot Water Moldability		
	Hydrolysis Resistant		
	Impact Modified		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.0	%	ASTM D955
Water Absorption (24 hr)	0.29	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	172	MPa	ASTM D638
Tensile Elongation (Break)	2.3	%	ASTM D638
Flexural Modulus	11200	MPa	ASTM D790
Flexural Strength	241	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	75	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	300	°C	ASTM D648
CLTE - Flow	7.2E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+17	ohms · cm	ASTM D257
Dielectric Strength ¹	20	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.59 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	104	°C	
Drying Time	4.0 to 8.0	hr	
Rear Temperature	327 to 360	°C	

Middle Temperature	327 to 360	°C
Front Temperature	327 to 360	°C
Processing (Melt) Temp	316 to 338	°C
Mold Temperature	93.3 to 149	°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

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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