

# HiFill® HiFill® PA6/6 GF/B40 IM L BK

Polyamide 66  
Techmer Engineered Solutions

Message:  
HiFill® HiFill® PA6/6 GF/B40 IM L BK is a polyamide 66 (nylon 66) product, which contains 20% glass fiber reinforced materials and 20% glass beads. It can be processed by injection molding and is available in North America. The main characteristics are: lubrication.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
	Glass beads, 20% filler by weight		
Additive	Lubricant		
Features	Lubrication		
Appearance	Available colors		
	Available colors		
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)	1.8	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	103	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	5650	MPa	ASTM D790
Flexural Strength	152	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	255	°C	ASTM D648
1.8 MPa, not annealed	210	°C	ASTM D648
CLTE - Flow	3.4E-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>	19	kV/mm	ASTM D149
Injection	Nominal Value	Unit	

Drying Temperature	82	°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 - 93	°C
Injection Rate	Moderate-Fast	
Back Pressure	0.345 - 0.689	MPa

#### Injection instructions

Screw Speed: Medium Recommendations for Molding and Tool Conditions: Well vented Moisture Content, as received: Product is packaged at 0.2% or less. Recommended Max Moisture: 0.12% down to 0.08%

#### NOTE

1. Method A (short time)

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

#### 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

