HiFill® PA6/6 GF30 IM HS L

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill®PA6/6 GF30 IM HS L is a polyamide 66 (nylon 66) product, which contains a 30% glass fiber reinforced material. It can be processed by injection molding and is available in North America. Features include: flame retardant/rated flame Impact modification Impact resistance heat stabilizer Lubrication

Filler / Reinforcement Glass fiber reinforced material, 30% filler by weight Additive Impact modifier heat stabilizer Lubricant Features Impact resistance, high Thermal Stability Lubrication Appearance Available colors Forms Particle Froms Injection molding Physical Nominal Value Unit Specific Gravity 1.31 g/cm³ ASTM D792 Molding Shrinkage - Flow (3.18 mm) 0.50 % ASTM D792 Marchanes Nominal Value Unit Test Method Rockwell Hardness (R-Scale) 111 Specific Gravity ASTM D795 Mechanical Nominal Value Unit Test Method Rockwell Hardness (R-Scale) 111 Specific Gravity ASTM D785 Marchanical Nominal Value Unit Test Method Rockwell Hardness (R-Scale) 145 MPa ASTM D638 Tensile Strength (Break) 145 MPa ASTM D638 Resural Modulus 6890 MPa ASTM D638 Resural Modulus 6890 MPa ASTM D556	General Information					
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0.45 MPa, not annealed 254 °C ASTM D648	Deflection Temperature Under Load			ASTM D648		
	0.45 MPa, not annealed	254	°C	ASTM D648		

1.8 MPa, not annealed	249	°C	ASTM D648
CLTE - Flow	7.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	ASTM D257
Volume Resistivity	1.0E+11	ohms•cm	ASTM D257
Dielectric Strength ¹	17	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	НВ		UL 94
Additional Information	Nominal Value		
TPCI #	9869101		
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	282 - 293	°C	
Middle Temperature	288 - 299	°C	
Front Temperature	277 - 288	°C	
Nozzle Temperature	271 - 304	°C	
Processing (Melt) Temp	282 - 304	°C	
Mold Temperature	79.4 - 104	°C	
Injection Rate	Slow-Moderate		
Back Pressure	0.00 - 0.345	MPa	
Injection instructions			

Screw Speed: SlowRecommendations for Molding and Tool Conditions: Well vented moldMoisture Content, as received: Product is packaged at 0.2% or less.

NOTE

1.

Method A (short time)

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