

# HiFill® PA4/6 CF40 IM HS

Polyamide 46

Techmer Engineered Solutions

## Message:

HiFill® PA4/6 CF40 IM HS is a Polyamide 46 (Nylon 46) product filled with 40% carbon fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

Heat Stabilizer

General Information				
Filler / Reinforcement		Carbon Fiber,40% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Appearance		Black		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.33	--	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.10	--	%	ASTM D955
Water Absorption (24 hr)	1.7	--	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Break)	241	207	MPa	ASTM D638
Tensile Elongation (Break)	1.7	3.2	%	ASTM D638
Flexural Modulus	22100	18600	MPa	ASTM D790
Flexural Strength	393	345	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	96	100	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	282	--	°C	ASTM D648
CLTE - Flow	1.8E-5	--	cm/cm/°C	ASTM D696
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	10	--	ohms · cm	ASTM D257
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.50 mm)	HB	--		UL 94
Injection	Dry	Unit		
Drying Temperature	85.0		°C	
Drying Time	4.0 to 8.0		hr	
Rear Temperature	282 to 316		°C	

Middle Temperature	282 to 316	°C
Front Temperature	282 to 316	°C
Processing (Melt) Temp	246 to 316	°C
Mold Temperature	87.8 to 127	°C
Back Pressure	0.00 to 0.345	MPa
Screw Speed	40 to 80	rpm

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Recommended distributors for this material

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