

# HiFill® PA6/6 LGF60 HS L BK 12mm

Polyamide 66  
Techmer Engineered Solutions

Message:

HiFill®PA6/6 LGF60 HS L BK 12mm is a polyamide 66 (nylon 66) product containing long glass fiber. It can be processed by injection molding and is available in North America.

Features include:

- heat stabilizer
- Lubrication

General Information			
Filler / Reinforcement	Long glass fiber		
Additive	heat stabilizer		
	Lubricant		
Features	Thermal Stability		
	Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.70	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20	%	ASTM D955
Water Absorption (24 hr)	0.35	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	248	MPa	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	21400	MPa	ASTM D790
Flexural Strength	365	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	230	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	No Break		ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	257	°C	ASTM D648
CLTE - Flow	2.3E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+11	ohms	ASTM D257
Volume Resistivity	1.0E+9	ohms · cm	ASTM D257

Dielectric Strength <sup>1</sup>	20	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°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	54.4 - 93.3	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.345 - 0.689	MPa	

#### Injection instructions

Screw Speed: Slow 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)

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#### Recommended distributors for this material

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