

HiFill® PA6 G/C50 A240 BK

Polyamide 6

Techmer Engineered Solutions

Message:

HiFill® PA6 G/C50 A240 BK is a Polyamide 6 (Nylon 6) product filled with 50% glass\ceramic. It can be processed by injection molding and is available in North America. Primary characteristic: flame rated.

General Information			
Filler / Reinforcement	Glass\Ceramic,50% Filler by Weight		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.59	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.10	%	ASTM D955
Water Absorption (24 hr)	0.50	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	179	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	12600	MPa	ASTM D790
Flexural Strength	276	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	91	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	1200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	218	°C	
1.8 MPa, Unannealed	216	°C	
CLTE - Flow	1.4E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength ¹	17	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value		
TPCI #	9809102		
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	

Drying Time	4.0	hr
Rear Temperature	260 to 304	°C
Middle Temperature	260 to 304	°C
Front Temperature	260 to 304	°C
Processing (Melt) Temp	243 to 271	°C
Mold Temperature	65.6 to 93.3	°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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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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