

# HiFill FR® PA6/6,6 FR NAT

Polyamide 66/6 Copolymer

Techmer Engineered Solutions

## Message:

HiFill FR® PA6/6,6 FR NAT is a Polyamide 66/6 Copolymer (Nylon 66/6) product. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

Flame Retardant

General Information			
Features	Flame Retardant		
Appearance	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.90	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	65.5	MPa	ASTM D638
Tensile Elongation (Yield)	60	%	ASTM D638
Flexural Modulus	1450	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	130	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	92.8	°C	ASTM D648
CLTE - Flow	5.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength <sup>1</sup>	21	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	> 6.0	hr	

Rear Temperature	254 to 277	°C
Middle Temperature	254 to 277	°C
Front Temperature	254 to 277	°C
Processing (Melt) Temp	249 to 271	°C
Mold Temperature	65.6 to 93.3	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	30 to 60	rpm

#### NOTE

1. Method A (Short-Time)

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#### Recommended distributors for this material

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