

# HiFill® PA6 GF30 IM HS L

Polyamide 6

Techmer Engineered Solutions

## Message:

HiFill®PA6 GF30 IM HS L is a polyamide 6 (nylon 6) product that contains a 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

General Information				
Filler / Reinforcement		Glass fiber reinforced material		
Additive		Impact modifier		
Features		Impact resistance, high		
Appearance		Available colors		
Forms		Particle		
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)	1.5	--	%	ASTM D570
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	120	--		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Break)	145	100	MPa	ASTM D638
Tensile Elongation (Break)	4.0	8.0	%	ASTM D638
Flexural Modulus	8270	4830	MPa	ASTM D790
Flexural Strength	234	165	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact				ASTM D256
-40°C, 3.18 mm	130	--	J/m	ASTM D256
23°C, 3.18 mm	190	340	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	1400 J/m	No Break		ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	210	--	°C	ASTM D648
CLTE - Flow	3.6E-5	--	cm/cm/°C	ASTM D696
Electrical	Dry	Conditioned	Unit	Test Method

Volume Resistivity	2.0E+15	--	ohms·cm	ASTM D257
Dielectric Strength <sup>1</sup>	15	--	kV/mm	ASTM D149
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating	HB	--		UL 94
Injection	Dry	Unit		
Drying Temperature	82.2		°C	
Drying Time	2.0 - 4.0		hr	
Suggested Max Moisture	0.10		%	
Rear Temperature	266 - 277		°C	
Middle Temperature	277 - 288		°C	
Front Temperature	271 - 282		°C	
Nozzle Temperature	271 - 282		°C	
Processing (Melt) Temp	277 - 288		°C	
Mold Temperature	79.4 - 104		°C	
Injection Rate	Slow-Moderate			
Back Pressure	0.00 - 0.345		MPa	
Injection instructions				
Screw Speed: MediumRecommendations 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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#### Recommended distributors for this material

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