

HiFill® PA4/6 GF30 FR HS L

Polyamide 46
Techmer Engineered Solutions

Message:

HiFill® PA4/6 GF30 FR HS L is a Polyamide 46 (Nylon 46) product filled with 30% glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated
Flame Retardant
Heat Stabilizer
Lubricated

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Heat Stabilizer Lubricant		
Features	Flame Retardant Heat Stabilized Lubricated		
UL File Number	E157318		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.68	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	110	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	4960	MPa	ASTM D790
Flexural Strength	165	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)	288	°C	ASTM D648
CLTE - Flow	3.6E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+11	ohms · cm	ASTM D257

Dielectric Strength ¹	24	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.59 mm)	V-0		UL 94
Injection	Nominal Value	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	
NOTE			
1.	Method A (Short-Time)		

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Recommended distributors for this material

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

