

HiFill® PA6/6 GF/M38 HS

Polyamide 66
Techmer Engineered Solutions

Message:
HiFill® PA6/6 GF/M38 HS is a polyamide 66 (nylon 66) product that contains 38% glass \minerals. It can be processed by injection molding and is available in North America. The main characteristics are: heat stabilizer.

General Information			
Filler / Reinforcement	Glass \mineral, 38% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.80	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	125	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	6620	MPa	ASTM D790
Flexural Strength	186	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	750	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	255	°C	ASTM D648
1.8 MPa, not annealed	235	°C	ASTM D648
CLTE - Flow	2.2E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+13	ohms · cm	ASTM D257
Dielectric Strength ¹	16	kV/mm	ASTM D149
Additional Information	Nominal Value		
TPCI #	9448101		
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: MediumRecommendations for Molding and Tool Conditions: Well ventedMoisture Content, as received: Product is packaged at 0.2% or less.Recomended Max Moisture: 0.12% down to 0.08%

NOTE

1. Method A (short time)

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