

HiFill® PA6/6 GF60 IM HS L

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill® PA6/6 GF60 IM HS L is a polyamide 66 (nylon 66) product, which contains a 60% glass fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

heat stabilizer

Lubrication

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 60% filler by weight		
Additive		heat stabilizer		
		Lubricant		
Features		Thermal Stability		
		Lubrication		
Appearance		Available colors		
		Natural color		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.67	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20	--	%	ASTM D955
Water Absorption (24 hr)	0.45	--	%	ASTM D570
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	121	--		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Break)	186	159	MPa	ASTM D638
Tensile Elongation (Break)	3.0	4.0	%	ASTM D638
Flexural Modulus	14500	11700	MPa	ASTM D790
Flexural Strength	276	241	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	370	430	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	No Break	No Break		ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed)	257	--	°C	ASTM D648
CLTE - Flow	2.3E-5	--	cm/cm/°C	ASTM D696
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+11	--	ohms	ASTM D257
Volume Resistivity	1.0E+9	--	ohms·cm	ASTM D257
Dielectric Strength ¹	20	--	kV/mm	ASTM D149
Additional Information	Dry	Conditioned		
TPCI #	8874101	--		
Injection	Dry	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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