

HiFill FR® PA6 GF/M45 L LE BK

Polyamide 6

Techmer Engineered Solutions

Message:

HiFill FR® PA6 GF/M45 L LE BK is a Polyamide 6 (Nylon 6) product filled with 50% glass\mineral. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

Flame Retardant

General Information			
Filler / Reinforcement	Glass\Mineral,50% Filler by Weight		
Features	Flame Retardant		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.51	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 3.18 mm	0.40	%	
Across Flow	0.70	%	
Water Absorption (24 hr)	0.55	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Break	186	MPa	
--	116	MPa	
Tensile Elongation			ASTM D638
Yield	3.9	%	
Break	2.5	%	
Flexural Modulus	8690	MPa	ASTM D790
Flexural Strength	221	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	750	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	216	°C	
1.8 MPa, Unannealed	202	°C	
CLTE - Flow	3.1E-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
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	2.0 to 4.0	hr	
Rear Temperature	232 to 257	°C	
Middle Temperature	232 to 257	°C	
Front Temperature	232 to 257	°C	
Processing (Melt) Temp	238 to 266	°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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