

# HiFill FR® PA6 GF25 FR

Polyamide 6

Techmer Engineered Solutions

## Message:

HiFill FR® PA6 GF25 FR is a Polyamide 6 (Nylon 6) product filled with glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

Flame Retardant

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	Flame Retardant		
Features	Flame Retardant		
UL File Number	E157318		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.54	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	124	MPa	ASTM D638
Tensile Elongation (Break)	4.2	%	ASTM D638
Flexural Modulus	6550	MPa	ASTM D790
Flexural Strength	165	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	216	°C	ASTM D648
CLTE - Flow	3.6E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	ASTM D257
Volume Resistivity	1.0E+14	ohms · cm	ASTM D257
Dielectric Strength <sup>1</sup>	16	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 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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#### Recommended distributors for this material

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