

# HiFill® PA6/6 GF43 IM L

Polyamide 66

Techmer Engineered Solutions

## Message:

HiFill® PA6/6 GF43 IM L is a polyamide 66 (nylon 66) product, which contains a 43% glass fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

Impact modification

Impact resistance

Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 43% filler by weight		
Additive	Impact modifier		
	Lubricant		
Features	Impact resistance, high		
	Lubrication		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.80	%	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	111		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	159	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	8960	MPa	ASTM D790
Flexural Strength	213	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	254	°C	ASTM D648
1.8 MPa, not annealed	249	°C	ASTM D648
CLTE - Flow	7.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method

Surface Resistivity	1.0E+12	ohms	ASTM D257
Volume Resistivity	1.0E+11	ohms·cm	ASTM D257
Dielectric Strength <sup>1</sup>	17	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Additional Information	Nominal Value		
TPCI #	6439101		
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	282 - 293	°C	
Middle Temperature	288 - 299	°C	
Front Temperature	277 - 288	°C	
Nozzle Temperature	271 - 304	°C	
Processing (Melt) Temp	282 - 304	°C	
Mold Temperature	79.4 - 104	°C	
Injection Rate	Slow-Moderate		
Back Pressure	0.00 - 0.345	MPa	
Injection instructions			
Screw Speed: SlowRecommendations for Molding and Tool Conditions: Well vented moldMoisture Content, as received: Product is packaged at 0.2% or less.			
NOTE			

1. Method A (short time)

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#### Recommended distributors for this material

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