

HiFill FR® PA6/6 FR IM

Polyamide 66
Techmer Engineered Solutions

Message:

HiFill FR® PA6/6 FR IM is a Polyamide 66 (Nylon 66) product. It can be processed by injection molding and is available in North America.

Characteristics include:

- Flame Rated
- Flame Retardant
- Impact Modified
- Impact Resistant

General Information			
Additive	Impact Modifier		
Features	Flame Retardant		
	High Impact Resistance		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.26	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.5	%	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	97		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	37.9	MPa	ASTM D638
Tensile Elongation (Yield)	60	%	ASTM D638
Flexural Modulus	1520	MPa	ASTM D790
Flexural Strength	55.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	590	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	73.9	°C	ASTM D648
CLTE - Flow	5.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	ASTM D257
Volume Resistivity	1.0E+14	ohms · cm	ASTM D257
Dielectric Strength ¹	21	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	> 6.0	hr
Rear Temperature	254 to 277	°C
Middle Temperature	254 to 277	°C
Front Temperature	254 to 277	°C
Processing (Melt) Temp	249 to 271	°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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