

# HiFill® PA6 GB15 L BK

Polyamide 6  
Techmer Engineered Solutions

Message:

HiFill® PA6 GB15 L BK is a Polyamide 6 (Nylon 6) product filled with 15% glass bead. It can be processed by injection molding and is available in North America.  
Characteristics include:  
Flame Rated  
Lubricated

General Information			
Filler / Reinforcement	Glass Bead, 15% Filler by Weight		
Additive	Lubricant		
Features	Lubricated		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.7	%	ASTM D955
Water Absorption (24 hr)	1.1	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	68.9	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	2760	MPa	ASTM D790
Flexural Strength	110	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	37	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	200	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	138	°C	
Melting Temperature	224	°C	
CLTE - Flow	5.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
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)	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	82.2	°C
Drying Time	4.0	hr
Rear Temperature	260 to 304	°C
Middle Temperature	260 to 304	°C
Front Temperature	260 to 304	°C
Processing (Melt) Temp	243 to 271	°C
Mold Temperature	65.6 to 93.3	°C
Back Pressure	0.00 to 0.345	MPa
Screw Speed	30 to 60	rpm

NOTE		
1.	Method A (Short-Time)	

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