

HiFill FR® PA6 GF33 FR-NR

Polyamide 66
Techmer Engineered Solutions

Message:

HiFill FR® PA6 GF33 FR-NR is a Polyamide 66 (Nylon 66) 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		
Features	Flame Retardant		
Appearance	Black		
	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.46	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.40	%	ASTM D955
Water Absorption (24 hr)	0.58	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	827	MPa	ISO 527-2
Tensile Strength (Break)	134	MPa	ASTM D638
Tensile Elongation (Break)	2.2	%	ASTM D638
Flexural Modulus	483	MPa	ASTM D790
Flexural Strength	138	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	100	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	216	°C	
CLTE - Flow	2.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	ASTM D257
Volume Resistivity	1.0E+13	ohms · cm	ASTM D257
Dielectric Strength ¹	20	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	> 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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