

HiFill® PA6/6 GF15 IM HS L

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill® PA6/6 GF15 IM HS L is a polyamide 66 (nylon 66) product, which contains a 15% 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

heat stabilizer

Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	Impact modifier heat stabilizer Lubricant		
Features	Impact resistance, high Thermal Stability Lubrication		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.6	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	111		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	84.1	MPa	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Flexural Modulus	3620	MPa	ASTM D790
Flexural Strength	110	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.18 mm	110	J/m	ASTM D256
23°C, 3.18 mm	190	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	252	°C	ASTM D648
1.8 MPa, not annealed	220	°C	ASTM D648
CLTE - Flow	7.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength ¹	19	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	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: Slow Recommendations for Molding and Tool Conditions: Well vented mold Moisture Content, as received: Product is packaged at 0.2% or less.

NOTE

- Method A (short time)

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