

HiFill® PA6 GF30 L

Polyamide 6
Techmer Engineered Solutions

Message:

HiFill® PA6 GF30 L is a Polyamide 6 (Nylon 6) product filled with 30% glass fiber. It can be processed by injection molding and is available in North America. Primary characteristic: lubricated.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Lubricant		
Features	Lubricated		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
	1.35		
Specific Gravity	1.37	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
	1.3		
Water Absorption (24 hr)	0.85	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
--	121		
R-Scale	118		
Mechanical	Nominal Value	Unit	Test Method
	176		
Tensile Strength (Break)	162	MPa	ASTM D638
	3.0		
Tensile Elongation (Break)	2.4	%	ASTM D638

8960

Flexural Modulus	1030	MPa	ASTM D790
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276

Flexural Strength	214	MPa	ASTM D790
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Impact	Nominal Value	Unit	Test Method
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Notched Izod Impact (23°C, 3.18 mm)	110	J/m	ASTM D256
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Unnotched Izod Impact (3.18 mm)	1100	J/m	ASTM D256
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Thermal	Nominal Value	Unit	Test Method
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Deflection Temperature Under Load			ASTM D648
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218

0.45 MPa, Unannealed	216	°C	
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1.8 MPa, Unannealed	210	°C	
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1.4E-5

CLTE - Flow	1.6E-5	cm/cm/°C	ASTM D696
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Electrical	Nominal Value	Unit	Test Method
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Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
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Dielectric Strength ¹	18	kV/mm	ASTM D149
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Additional Information	Nominal Value		
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TPCI #	7223102		
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Injection	Nominal Value	Unit	
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Drying Temperature	82.2	°C	
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Drying Time	4.0	hr	
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Rear Temperature	260 to 304	°C	
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Middle Temperature	260 to 304	°C	
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Front Temperature	260 to 304	°C	
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Processing (Melt) Temp	243 to 271	°C	
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Mold Temperature	65.6 to 93.3	°C	
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Back Pressure	0.00 to 0.345	MPa	
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Screw Speed	30 to 60	rpm	
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NOTE			
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1.	Method A (Short-Time)		
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