

HiFill® PA6 GF/M30 HS BK

Polyamide 6
Techmer Engineered Solutions

Message:

HiFill® PA6 GF/M30 HS BK is a Polyamide 6 (Nylon 6) product filled with 10% glass fiber and 20% mineral. It can be processed by injection molding and is available in North America.

Characteristics include:

Heat Stabilizer
Lubricated

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
	Mineral,20% Filler by Weight		
Additive	Heat Stabilizer		
	Lubricant		
Features	Heat Stabilized		
	Lubricated		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.0	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	75.8	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	5030	MPa	ASTM D790
Flexural Strength	124	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.18 mm	21	J/m	
23°C, 3.18 mm	43	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	210	°C	

1.8 MPa, Unannealed	196	°C	
CLTE - Flow	3.1E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+13	ohms·cm	ASTM D257
Dielectric Strength ¹	16	kV/mm	ASTM D149
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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