

HiFill® PA6 GF50 HS L

Polyamide 6
Techmer Engineered Solutions

Message:

HiFill® PA6 GF50 HS L is a Polyamide 6 (Nylon 6) product filled with 50% glass fiber. It can be processed by injection molding and is available in North America.
Characteristics include:
Heat Stabilizer
Lubricated

General Information				
Filler / Reinforcement		Glass Fiber,50% Filler by Weight		
Additive		Heat Stabilizer		
		Lubricant		
Features		Heat Stabilized		
		Lubricated		
Appearance		Colors Available		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.57	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	--	%	ASTM D955
Water Absorption (24 hr)	0.75	--	%	ASTM D570
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	121	--		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Break)	221	193	MPa	ASTM D638
Tensile Elongation (Break)	2.5	4.0	%	ASTM D638
Flexural Modulus	14100	10700	MPa	ASTM D790
Flexural Strength	290	269	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	160	270	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	1100 J/m	No Break		ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, Unannealed	218	--	°C	

1.8 MPa, Unannealed	216	--	°C	
CLTE - Flow	1.4E-5	--	cm/cm/°C	ASTM D696
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+15	--	ohms·cm	ASTM D257
Dielectric Strength ¹	18	--	kV/mm	ASTM D149
Injection	Dry	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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