

# HiFill® PA6/6 GF33 HR L

Polyamide 66

Techmer Engineered Solutions

## Message:

HiFill® PA6/6 GF33 HR L is a polyamide 66 (nylon 66) product, which contains a 33% glass fiber reinforced material. It can be processed by injection molding and is available in North America. The main characteristics are: lubrication.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 33% filler by weight		
Additive	Lubricant		
Features	Hydrolysis resistance		
	Lubrication		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Water Absorption (24 hr)	1.8	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	186	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	8960	MPa	ASTM D790
Flexural Strength	228	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, not annealed	259	°C	ASTM D648
1.8 MPa, not annealed	256	°C	ASTM D648
CLTE - Flow	2.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength <sup>1</sup>	19	kV/mm	ASTM D149
Additional Information	Nominal Value		
TPCI #	9357101		
Injection	Nominal Value	Unit	

Drying Temperature	82.2	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.12	%
Rear Temperature	282 - 293	°C
Middle Temperature	288 - 299	°C
Front Temperature	277 - 288	°C
Nozzle Temperature	282 - 293	°C
Processing (Melt) Temp	282 - 304	°C
Mold Temperature	54.4 - 93.3	°C
Injection Rate	Moderate-Fast	
Back Pressure	0.345 - 0.689	MPa

#### Injection instructions

Screw Speed: Medium Recommendations for Molding and Tool Conditions: Well vented Moisture Content, as received: Product is packaged at 0.2% or less. Recommended Max Moisture: 0.12% down to 0.08%

#### NOTE

1. Method A (short time)

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#### Recommended distributors for this material

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