HiFill® PA6/6 GF/M25 HS L BK

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill®PA6/6 GF/M25 HS L BK is a polyamide 66 (nylon 66) product, which contains 25% glass \minerals. It can be processed by injection molding and is available in North America.
Features include:
heat stabilizer
Lubrication

General Information			
Filler / Reinforcement	Glass \mineral, 25% filler by weight		
Additive	heat stabilizer Lubricant		
Features	Thermal Stability Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.33	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	86.2	MPa	ASTM D638
Tensile Elongation (Break)	2.0 - 4.0	%	ASTM D638
Flexural Modulus	4150	MPa	ASTM D790
Flexural Strength	130	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 3.18 mm)	43	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	590	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	249	°C	ASTM D648
1.8 MPa, not annealed	227	°C	ASTM D648
CLTE - Flow	5.6E-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	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: MediumRecommendations for Molding and Tool Conditions: Well ventedMoisture Content, as received: Product is packaged at 0.2% or less.Recomended Max Moisture: 0.12% down to 0.08%

NOTE	
1.	Method A (short time)

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

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Phone: +86 13424755533

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