

HiFill® PA6/6 GF20 SL4 HS BK

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill® PA6/6 GF20 SL4 HS BK is a polyamide 66 (nylon 66) product, which contains a 20% glass fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

Lubrication

heat stabilizer

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	Silicone lubricant (4%) heat stabilizer Lubricant		
Features	Thermal Stability Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	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)	131	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	5520	MPa	ASTM D790
Flexural Strength	172	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	255	°C	ASTM D648
1.8 MPa, not annealed	243	°C	ASTM D648
CLTE - Flow	3.1E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method

Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength ¹	19	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: 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

- Method A (short time)

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