

HiFill® PA6 GF35 HS L

Polyamide 6
Techmer Engineered Solutions

Message:

HiFill® PA6 GF35 HS L is a Polyamide 6 (Nylon 6) product filled with glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated
Heat Stabilizer
Lubricated

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	Heat Stabilizer		
	Lubricant		
Features	Heat Stabilized		
	Lubricated		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	195	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	9310	MPa	ASTM D790
Flexural Strength	238	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	180	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	1300	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	218	°C	
1.8 MPa, Unannealed	216	°C	
Melting Temperature	218	°C	
CLTE - Flow	3.1E-5	cm/cm/°C	ASTM D696

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.0E+15	ohms·cm	ASTM D257
Dielectric Strength ¹	19	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
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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