HiFill® PA6/6 GF/M20 IM BK

Polyamide 66

Techmer Engineered Solutions

Message:

HiFill®PA6/6 GF/M20 IM BK is a polyamide 66 (nylon 66) product, which contains 20% glass \minerals. It can be processed by injection molding and is available in North America.
Features include:
Impact modification
Impact resistance
heat stabilizer
Lubrication

General Information			
Filler / Reinforcement	Glass \mineral, 20% filler by weight		
Additive	Impact modifier heat stabilizer Lubricant		
Features	Impact resistance, high Thermal Stability Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.25	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.70	%	ASTM D955
Water Absorption (24 hr)	1.2	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	75.8	MPa	ASTM D638
Tensile Elongation (Break)	4.5	%	ASTM D638
Flexural Modulus	4140	MPa	ASTM D790
Flexural Strength	124	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 3.18 mm)	75	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	252	°C	ASTM D648
1.8 MPa, not annealed	210	°C	ASTM D648

CLTE - Flow	3.2E-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: 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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WECHAT