

Integra™ PA6/6 GA6.6 HSL BK-4000

PolySource, LLC - Polyamide 66

General Information
Product Description

PA 6/6, 33% Glass Fiber Reinforced, Heat Stabilized, Lubricated, Black

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Heat Stabilizer • Lubricant
Features	• Heat Stabilized • Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.40	g/cm ³	ISO 1183/A
Molding Shrinkage			ISO 294-4
Across Flow	0.90	%	
Flow	0.40	%	
Water Absorption (24 hr, 73°F)	0.80	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	1.7	%	ISO 62
Moisture Content	0.10	%	ASTM D6869
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.45E+6	psi	ISO 527-1
Tensile Stress (Break)	28300	psi	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	1.46E+6	psi	ISO 178
Flexural Stress	40600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	5.2	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact Strength (73°F)	4.8	ft·lb/in ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	482	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	464	°F	ISO 75-2/A
Melting Temperature	504	°F	ISO 11357-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	4.0	hr
Rear Temperature	536 to 590	°F
Middle Temperature	536 to 590	°F
Front Temperature	536 to 590	°F
Nozzle Temperature	536 to 590	°F
Processing (Melt) Temp	545 to 581	°F
Mold Temperature	149 to 203	°F

