

HiFill FR® J-71/20/VO/ND NATL

Techmer Polymer Modifiers - Polyamide 6

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	15400	psi	ASTM D638
Tensile Stress (Yield)	15600	psi	ISO 527-2
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	1.09E+6	psi	ASTM D790
Flexural Strength	23400	psi	ASTM D790
Flexural Stress	24400	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft·lb/in	ASTM D256
Notched Izod Impact Strength (0.125 in)	2.8	ft·lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	303	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	470 to 500	°F
Middle Temperature	480 to 510	°F
Front Temperature	490 to 520	°F
Nozzle Temperature	500 to 530	°F
Processing (Melt) Temp	480 to 525	°F
Mold Temperature	100 to 200	°F
Injection Rate		Slow
Back Pressure	0.00 to 50.0	psi
Screw Speed		Slow-Moderate

