

HiFill FR® PA6 G/CF33 FR HS L BK009

Techmer Polymer Modifiers - Polyamide 6

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.53		ASTM D792
Molding Shrinkage - Flow (0.125 in)	9.0E-3 to 0.011	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.30E+6	psi	ASTM D638
Tensile Strength (Yield)	25000	psi	ASTM D638
Tensile Strength (Break)	25000	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.2	ft·lb/in	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+8	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.12 in	V-0		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	460 to 500	°F
Middle Temperature	470 to 510	°F
Front Temperature	480 to 520	°F
Nozzle Temperature	490 to 530	°F
Processing (Melt) Temp	470 to 530	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

