

HiFill® J-75/30 BK223

Techmer Polymer Modifiers - Polyamide 6

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.26		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.35	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	17500	psi	ASTM D638
Tensile Strength (Break)	17000	psi	ASTM D638
Tensile Elongation (Break)	4.3	%	ASTM D638
Flexural Modulus	1.10E+6	psi	ASTM D790
Flexural Strength	23000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.6	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	330	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	440 to 480	°F
Middle Temperature	450 to 490	°F
Front Temperature	460 to 500	°F
Nozzle Temperature	470 to 510	°F
Processing (Melt) Temp	450 to 515	°F
Mold Temperature	100 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

