

HiFill FR® PA6 GF/M50 FR

Techmer Polymer Modifiers - Polyamide 6

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber\Mineral, 50% Filler by Weight
Features	• Flame Retardant
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.51		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	16800	psi	ASTM D638
Tensile Elongation (Break)	3.9	%	ASTM D638
Flexural Modulus	1.26E+6	psi	ASTM D790
Flexural Strength	32000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	420	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	395	°F	ASTM D648
CLTE - Flow	1.7E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms-cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	400	V/mil	ASTM D149

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	450 to 495	°F
Middle Temperature	450 to 495	°F
Front Temperature	450 to 495	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm

