



## HiFill® PA6 G/M40 L UV

Techmer Polymer Modifiers - Polyamide 6

### General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass/Mineral, 40% Filler by Weight
Additive	• Lubricant                      • UV Stabilizer
Features	• Lubricated                      • UV Resistant
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

### ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.50		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	19000	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	1.30E+6	psi	ASTM D790
Flexural Strength	30000	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.31		
vs. Steel - Static	0.24		
Wear Factor	85	10 <sup>-10</sup> in <sup>3</sup> ·min/ft·lb·hr	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.3	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	410	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	400	°F	ASTM D648
CLTE - Flow	9.0E-6	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	400	V/mil	ASTM D149
Additional Information	Nominal Value	Unit	Test Method
TPCI #	6024102		

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	4.0	hr
Rear Temperature	500 to 580	°F
Middle Temperature	500 to 580	°F
Front Temperature	500 to 580	°F
Processing (Melt) Temp	470 to 520	°F
Mold Temperature	150 to 200	°F
Back Pressure	0.00 to 50.0	psi
Screw Speed	30 to 60	rpm

