

HiFill® PA6 GF/B30 IM L BK

Techmer Polymer Modifiers - Polyamide 6

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Bead\Glass Fiber, 30% Filler by Weight
Additive	• Impact Modifier
Features	• Lubricated
Appearance	• Black • Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.31		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.017	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	71000	psi	ASTM D638
Tensile Strength (Yield)	9300	psi	ASTM D638
Tensile Strength (Break)	9000	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.3	ft-lb/in	ASTM D256
Notched Izod Impact (Area)	2.00	ft-lb/in ²	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Thermal	Nominal Value	Unit	Test Method
CLTE - Flow	1.1E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

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

