

HiFill® PA6 GF/M15 A1 BK

Techmer Polymer Modifiers - Polyamide 6

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber\Mineral, 15% Filler by Weight
Additive	• Heat Stabilizer
Features	• Heat Stabilized
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.22		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.015	in/in	ASTM D955
Water Absorption (24 hr)	0.85	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	11000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	410000	psi	ASTM D790
Flexural Strength	17000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.1	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	390	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	270	°F	ASTM D648
Melting Temperature	420	°F	
CLTE - Flow	2.9E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	520	V/mil	ASTM D149
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

