HiFill® PA6 LG/LCF30 2000 12mm

Techmer Polymer Modifiers - *Polyamide 6*

General			
Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Long Carbon Fiber	• Long Glass Fiber	
Features	• Heat Stabilized	• Lubricated	
Appearance	• Colors Available • Colors Available	• Colors Available • Colors Available	• Natural Color
Forms	• Pellets [1]		
Processing Method	• Injection Molding		

Properties [2]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.32	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20 to 0.50	%	ASTM D955
Water Absorption (24 hr)	0.35	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	248	MPa	ASTM D638
Tensile Elongation (Break)	2.0 to 3.0	%	ASTM D638
Flexural Modulus	13100	MPa	ASTM D790
Flexural Strength	331	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 3.18 mm)	240	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	850	J/m	ASTM D4812
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	207	°C	ASTM D648
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	20	kV/mm	ASTM D149

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	82	°C
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	254 to 266	°C
Middle Temperature	260 to 271	°C
Front Temperature	249 to 260	°C
Nozzle Temperature	282 to 293	°C
Processing (Melt) Temp	260 to 304	°C
Mold Temperature	54 to 93	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 0.517	MPa

Injection Notes

Screw Speed: Slow
Recommendations for Molding and Tool Conditions: Well vented

Moisture Content, as received: Product is packaged at 0.2% or less.
Recomended Max Moisture: 0.12% down to 0.08%