

HiFill FR® PA4/6 GF10 FR HS L GN611660

Techmer Polymer Modifiers - Polyamide 46

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Additive	• Flame Retardant • Heat Stabilizer
Features	• Flame Retardant • Heat Stabilized
Appearance	• Green
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.52		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	750000	psi	ASTM D638
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Strength (Break)	8500	psi	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.60	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.12 in	V-0		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	200	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	570 to 600	°F
Middle Temperature	580 to 610	°F
Front Temperature	590 to 620	°F
Nozzle Temperature	595 to 625	°F
Processing (Melt) Temp	570 to 625	°F
Mold Temperature	150 to 250	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

