

HiFill® PA4/6 GF5 HS BK002

Techmer Polymer Modifiers - Polyamide 46

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 5.0% Filler by Weight
Additive	• Heat Stabilizer
Features	• Heat Stabilized
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	567000	psi	ASTM D638
Tensile Strength (Yield)	12700	psi	ASTM D638
Tensile Strength (Break)	12700	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.76	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	200	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	560 to 570	°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	

