

HiFill® PA4/6 GF33 HS NAT

Techmer Polymer Modifiers - Polyamide 46

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Heat Stabilizer
Features	• Heat Stabilized
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.43		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Mechanical			
Tensile Strength (Break)	30000	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	1.30E+6	psi	ASTM D790
Flexural Strength	37000	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.125 in)	1.8	ft·lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	555	°F	ASTM D648
Melting Temperature	563	°F	
CLTE - Flow	1.0E-5	in/in/°F	ASTM D696
Electrical			
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	600	V/mil	ASTM D149
Flammability			
Flame Rating (0.06 in)	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	185	°F
Drying Time	4.0 to 8.0	hr
Rear Temperature	540 to 600	°F
Middle Temperature	540 to 600	°F
Front Temperature	540 to 600	°F
Processing (Melt) Temp	475 to 600	°F
Mold Temperature	190 to 260	°F
Back Pressure	0.00 to 50.0	psi
Screw Speed	40 to 80	rpm

