

HiFill® PA11 GF20 HS NAT

Techmer Polymer Modifiers - Polyamide 10

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Additive	• Heat Stabilizer
Features	• Heat Stabilized
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	650000	psi	ASTM D638
Tensile Strength (Yield)	11500	psi	ASTM D638
Tensile Strength (Break)	11000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	670000	psi	ASTM D790
Flexural Strength	16000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.0	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	450 to 500	°F
Middle Temperature	460 to 510	°F
Front Temperature	470 to 520	°F
Nozzle Temperature	480 to 530	°F
Processing (Melt) Temp	455 to 535	°F
Mold Temperature	100 to 175	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

