

HiFill FR® J-1/30/FR NAT

Techmer Polymer Modifiers - Polyamide 66

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.71		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.64E+6	psi	ASTM D638
Tensile Strength (Yield)	23000	psi	ASTM D638
Tensile Strength (Break)	22500	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	1.87E+6	psi	ASTM D790
Flexural Strength	31500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.7	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.12 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	510 to 540	°F
Middle Temperature	520 to 550	°F
Front Temperature	530 to 560	°F
Nozzle Temperature	540 to 570	°F
Processing (Melt) Temp	520 to 565	°F
Mold Temperature	175 to 250	°F
Injection Rate		Slow
Back Pressure	0.00 to 50.0	psi
Screw Speed		Slow-Moderate

