

HiFill FR® J-1/30/FR BK

Techmer Polymer Modifiers - Polyamide 66

General

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

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|---|---------------|----------|-------------|
| Density / Specific Gravity | 1.67 | | ASTM D792 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 1.80E+6 | psi | ASTM D638 |
| Tensile Strength (Yield) | 20000 | psi | ASTM D638 |
| Tensile Strength (Break) | 20000 | psi | ASTM D638 |
| Tensile Elongation (Break) | 1.8 | % | ASTM D638 |
| Flexural Modulus | 1.70E+6 | psi | ASTM D790 |
| Flexural Strength | 32000 | psi | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 1.5 | ft·lb/in | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load (264 psi, Unannealed) | 480 | °F | ASTM D648 |
| 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 | 3.0 to 4.0 | 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 |

