

HiFill FR® PA6/6 GF25 FR-N IM NAT

Techmer Polymer Modifiers - Polyamide 66

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Additive	• Flame Retardant • Impact Modifier
Features	• Flame Retardant • Impact Modified
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		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	950000	psi	ASTM D638
Tensile Strength (Yield)	16000	psi	ASTM D638
Tensile Strength (Break)	16000	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	970000	psi	ASTM D790
Flexural Strength	26000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.5	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	465	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.12 in	V-0		

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	535 to 565	°F
Processing (Melt) Temp	520 to 560	°F
Mold Temperature	175 to 250	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

