

HiFill FR® PA6/6 GF25 FR IM BK94027

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	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.36		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	850000	psi	ASTM D638
Tensile Strength (Yield)	13500	psi	ASTM D638
Tensile Strength (Break)	13000	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	970000	psi	ASTM D790
Flexural Strength	19000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.6	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	402	°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	2.0 to 3.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	500 to 540	°F
Front Temperature	510 to 550	°F
Nozzle Temperature	520 to 555	°F
Processing (Melt) Temp	500 to 555	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

