

HiFill FR® PA6/6 FR 346 RD

Techmer Polymer Modifiers - Polyamide 66

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Heat Stabilizer • Lubricant
Features	• Flame Retardant • Heat Stabilized • Lubricated
Appearance	• Colors Available • Red
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.22		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.018	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Break)	60	%	ASTM D638
Flexural Modulus	37000	psi	ASTM D790
Flexural Strength	13200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	1.3	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	400	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	145	°F	ASTM D648
CLTE - Flow	5.1E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	690	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.031 in	V-0		
0.12 in	5VA		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	> 6.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	490 to 530	°F
Front Temperature	490 to 530	°F
Processing (Melt) Temp	480 to 520	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm

