

HiFill FR® PA6/6 FR IM BK

Techmer Polymer Modifiers - Polyamide 66

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Flame Retardant • Impact Modified
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.34		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.013	in/in	ASTM D955
Water Absorption (24 hr)	1.1	%	ASTM D570
Mechanical			
Tensile Strength (Yield)	7000	psi	ASTM D638
Tensile Elongation (Break)	50	%	ASTM D638
Flexural Modulus	220000	psi	ASTM D790
Flexural Strength	8200	psi	ASTM D790
Impact			
Notched Izod Impact	14	ft·lb/in	ASTM D256
Hardness			
Rockwell Hardness (R-Scale)	112		ASTM D785
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	152	°F	ASTM D648
CLTE - Flow	3.3E-5	in/in/°F	ASTM D696
Electrical			
Surface Resistivity	1.0E+12	ohms	ASTM D257
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	530	V/mil	ASTM D149
Flammability			
Flame Rating (0.06 in)	V-0		UL 94
Additional Information			
TPCI #	9993101		

Processing Information

	Nominal Value	Unit
Injection		
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

