HiFill® PA6/6 E GF33 LE

Techmer Polymer Modifiers - *Polyamide 66*

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Features	• Low Extractables
Agency Ratings	• FDA
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Extrusion

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.37		ASTM D792
Melt Mass-Flow Rate (MFR) (275°C/2.16 kg)	9.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.8	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	26000	psi	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	1.40E+6	psi	ASTM D790
Flexural Strength	32000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (0.125 in)	1.9	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)	499	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	492	°F	ASTM D648
CLTE - Flow	1.1E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	490	V/mil	ASTM D149

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.12	%
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	540 to 560	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	130 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi

Injection Notes

Screw Speed: Medium
Recommendations for Molding and Tool Conditions: Well vented

Moisture Content, as received: Product is packaged at 0.2% or less.
Recomended Max Moisture: 0.12% down to 0.08%