

**HiFill FR® PA6/6 T40 AF23 IM FR BK95030**

Techmer Polymer Modifiers - Polyamide 66

**General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Aramid Fiber
Additive	• Flame Retardant      • Impact Modifier
Features	• Flame Retardant      • Impact Modified
Appearance	• Black
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.24		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Strength (Yield)	13600	psi	ASTM D638
Tensile Strength (Break)	13500	psi	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus	650000	psi	ASTM D790
Flexural Strength	20000	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	1.3	ft·lb/in	ASTM D256
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating			UL 94
0.06 in		V-0	
0.12 in		V-0	

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	470 to 490	°F
Middle Temperature	480 to 500	°F
Front Temperature	490 to 510	°F
Nozzle Temperature	500 to 520	°F
Processing (Melt) Temp	480 to 525	°F
Mold Temperature	100 to 200	°F
Injection Rate		Slow
Back Pressure	0.00 to 50.0	psi
Screw Speed		Slow-Moderate

