

## HiFill® PA6/6,6 IM3 BK

Techmer Polymer Modifiers - Polyamide 66/6 Copolymer

### General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Heat Stabilizer • Impact Modifier • Lubricant
Features	• Copolymer • High Impact Resistance • Heat Stabilized • Lubricated
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

### ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.09		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.016	in/in	ASTM D955
Water Absorption (24 hr)	1.8	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	8800	psi	ASTM D638
Tensile Elongation (Yield)	50	%	ASTM D638
Flexural Modulus	385000	psi	ASTM D790
Flexural Strength	12000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	2.5	ft·lb/in	
73°F, 0.125 in	12	ft·lb/in	
Unnotched Izod Impact (0.125 in)	No Break		ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	111		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)	140	°F	ASTM D648
CLTE - Flow	4.4E-5	in/in/°F	ASTM D696

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	2.0 to 4.0	%
Rear Temperature	510 to 580	°F
Middle Temperature	510 to 580	°F
Front Temperature	510 to 580	°F
Processing (Melt) Temp	500 to 540	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm

