

HiFill® PA6/6 CM25 HS BK

Techmer Polymer Modifiers - Polyamide 66

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Mineral, 25% Filler by Weight
Additive	• Heat Stabilizer
Features	• Heat Stabilized
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.32		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.012	in/in	ASTM D955
Water Absorption (24 hr)	0.85	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	12000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	600000	psi	ASTM D790
Flexural Strength	18000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	0.80	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	485	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648
Melting Temperature	490	°F	
CLTE - Flow	2.9E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	3.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	520	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94

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%

