

HiFill® PA6/6 408 IM L LE

Techmer Polymer Modifiers - Polyamide 66

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.08		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	250000	psi	ASTM D638
Tensile Strength (Yield)	7500	psi	ASTM D638
Tensile Strength (Break)	6500	psi	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	10	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	205	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	500 to 530	°F
Middle Temperature	510 to 540	°F
Front Temperature	520 to 550	°F
Nozzle Temperature	525 to 555	°F
Processing (Melt) Temp	500 to 555	°F
Mold Temperature	125 to 225	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

