HiFill FR® PA6/6,6 FR NAT

Techmer Polymer Modifiers - *Polyamide 66/6 Copolymer*

General		
Material Status	• Commercial: Active	
Availability	• North America	
Features	• Flame Retardant	
Appearance	• Colors Available	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.19		ASTM D792
Molding Shrinkage - Flow (0.125 in)	9.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	9500	psi	ASTM D638
Tensile Elongation (Yield)	60	%	ASTM D638
Flexural Modulus	210000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	2.5	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	112		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	199	°F	ASTM D648
CLTE - Flow	3.3E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+12	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	530	V/mil	ASTM D149
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.03 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	> 6.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	490 to 530	°F
Front Temperature	490 to 530	°F
Processing (Melt) Temp	480 to 520	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm