

HiFill® PA6/6,6 109 L N3

Techmer Polymer Modifiers - *Polyamide 66/6 Copolymer*

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Lubricant
Features	• Lubricated
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.14		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	532000	psi	ASTM D638
Tensile Strength (Yield)	11700	psi	ASTM D638
Tensile Strength (Break)	10300	psi	ASTM D638
Tensile Elongation (Break)	27	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.60	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	391	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	141	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	4.0	hr
Rear Temperature	520 to 540	°F
Middle Temperature	520 to 540	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 540	°F
Processing (Melt) Temp	535 to 570	°F
Mold Temperature	150 to 180	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

