HiFill® EXP149350-4

Techmer Polymer Modifiers - *Polyamide 66/6 Copolymer*

General		
Material Status	• Commercial: Active	
Availability	• North America	
Filler / Reinforcement	• Glass Fiber\Carbon Fiber, 30% Filler by Weight	
Additive	• Heat Stabilizer	• Lubricant
Features	• Heat Stabilized	• Lubricated
Appearance	• Black	
Forms	• Pellets	
Processing Method	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.33E+6	psi	ASTM D638
Tensile Strength (Yield)	23300	psi	ASTM D638
Tensile Elongation (Break, 73°F)	3.4	%	ASTM D638
Flexural Modulus	1.53E+6	psi	ASTM D790
Flexural Strength	33000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	1.2	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	436	°F	ASTM D648
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+3 to 1.0E+5	ohms	ASTM D257
Volume Resistivity	1.0E+3 to 1.0E+5	ohms·cm	ASTM D257

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	530 to 570	°F
Middle Temperature	530 to 570	°F
Front Temperature	530 to 580	°F
Nozzle Temperature	540 to 560	°F
Processing (Melt) Temp	540 to 600	°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%