

HiFill® PA6/6,6 IM 6040 MB

Techmer Polymer Modifiers - *Polyamide 66/6 Copolymer*

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Heat Stabilizer • Lubricant • Impact Modifier • Nucleating Agent
Features	• Copolymer • Impact Modified • Nucleated • Heat Stabilized • Lubricated
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.11		ASTM D792
Molding Shrinkage - Flow	0.013	in/in	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Mechanical			
Tensile Strength (Yield)	8100	psi	ASTM D638
Tensile Elongation (Break)	60	%	ASTM D638
Flexural Modulus	270000	psi	ASTM D790
Flexural Strength	12100	psi	ASTM D790
Impact			
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	2.0	ft·lb/in	
-4°F, 0.125 in	4.0	ft·lb/in	
73°F, 0.125 in	7.0	ft·lb/in	
Hardness			
Rockwell Hardness (R-Scale)	110		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	345	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	150	°F	ASTM D648
CLTE - Flow	5.3E-5	in/in/°F	ASTM D696
Electrical			
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	460	V/mil	ASTM D149
Flammability			
Flame Rating	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	2.0 to 4.0	%
Rear Temperature	510 to 580	°F
Middle Temperature	510 to 580	°F
Front Temperature	510 to 580	°F
Processing (Melt) Temp	500 to 540	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi



