

HiFill FR® J-4/30/VO BK2989

Techmer Polymer Modifiers - *Polyamide 612*

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	20800	psi	ASTM D638
Tensile Elongation (Break)	2.3	%	ASTM D638
Flexural Modulus	1.47E+6	psi	ASTM D790
Flexural Strength	32600	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.6	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	385	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.030 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	500 to 540	°F
Middle Temperature	510 to 550	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	525 to 560	°F
Processing (Melt) Temp	500 to 555	°F
Mold Temperature	125 to 175	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

