

HiFill® PA6/12 GF30 LE BK

Techmer Polymer Modifiers - Polyamide 612

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Agency Ratings	• FDA
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.31		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 0.010	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.33E+6	psi	ASTM D638
Tensile Strength (Yield)	22500	psi	ASTM D638
Tensile Strength (Break)	22500	psi	ASTM D638
Tensile Elongation (Break)	2.8	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.8	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	480 to 520	°F
Middle Temperature	490 to 530	°F
Front Temperature	500 to 540	°F
Nozzle Temperature	510 to 550	°F
Processing (Melt) Temp	490 to 550	°F
Mold Temperature	125 to 200	°F
Injection Rate	Moderate	
Back Pressure	25.0 to 50.0	psi
Screw Speed	Slow-Moderate	

