

**HiFill® PA6/10 AF33 IM BK**

Techmer Polymer Modifiers - Polyamide 610

**General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Aramid Fiber, 33% Filler by Weight
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Black
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.14		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	500000	psi	ASTM D638
Tensile Strength (Yield)	15000	psi	ASTM D638
Tensile Elongation (Break)	15	%	ASTM D638
Flexural Modulus	500000	psi	ASTM D790
Flexural Strength	17000	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	3.6	ft·lb/in	ASTM D256

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	460 to 490	°F
Middle Temperature	470 to 500	°F
Front Temperature	480 to 510	°F
Nozzle Temperature	490 to 520	°F
Processing (Melt) Temp	470 to 520	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

