

HiFill® PA6/12 LE NAT

Techmer Polymer Modifiers - Polyamide 612

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.10E+8	psi	ASTM D638
Tensile Strength (Yield)	14000	psi	ASTM D638
Tensile Strength (Break)	13500	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.5	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	470 to 490	°F
Middle Temperature	480 to 500	°F
Front Temperature	490 to 510	°F
Nozzle Temperature	500 to 520	°F
Processing (Melt) Temp	480 to 525	°F
Mold Temperature	100 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

