

HiFill® PA6/10 IM NAT1

Techmer Polymer Modifiers - Polyamide 610

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.02		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	190000	psi	ASTM D638
Tensile Strength (Yield)	5000	psi	ASTM D638
Tensile Strength (Break)	4500	psi	ASTM D638
Tensile Elongation (Yield)	4.5	%	ASTM D638
Tensile Elongation (Break)	150	%	ASTM D638
Flexural Modulus	180000	psi	ASTM D790
Flexural Strength	6800	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	15	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	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	

