

HiFill® PA6/12 GM30 HS L BK

Techmer Polymer Modifiers - Polyamide 612

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Additive	• Heat Stabilizer
Features	• Heat Stabilized
Appearance	• Black
Processing Method	• Injection Molding

Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.31		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	800000	psi	ASTM D638
Tensile Strength (Yield)	7500	psi	ASTM D638
Tensile Strength (Break)	7500	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	670000	psi	ASTM D790
Flexural Strength	20000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.40	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	510 to 550	°F
Middle Temperature	520 to 560	°F
Front Temperature	530 to 570	°F
Nozzle Temperature	520 to 560	°F
Processing (Melt) Temp	510 to 560	°F
Mold Temperature	150 to 225	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

