

HiFill® PA6/12 BK001

Techmer Polymer Modifiers - Polyamide 612

General

| | |
|-------------------|----------------------|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Appearance | • Black |
| Processing Method | • Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|---|----------------------|-------------|--------------------|
| Density / Specific Gravity | 1.07 | | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (250°C/2.16 kg) | 56 | g/10 min | ASTM D1238 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 340000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 9600 | psi | ASTM D638 |
| Tensile Elongation (Break) | 28 | % | ASTM D638 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 0.70 | ft·lb/in | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load (264 psi, Unannealed) | 158 | °F | ASTM D648 |

Processing Information

| Injection | Nominal Value | Unit |
|------------------------|----------------------|-------------|
| Drying Temperature | 180 | °F |
| Drying Time | 2.0 to 3.0 | hr |
| Rear Temperature | 500 to 540 | °F |
| Middle Temperature | 510 to 550 | °F |
| Front Temperature | 520 to 560 | °F |
| Nozzle Temperature | 525 to 560 | °F |
| Processing (Melt) Temp | 500 to 555 | °F |
| Mold Temperature | 125 to 175 | °F |
| Injection Rate | Slow | |
| Back Pressure | 25.0 to 75.0 | psi |
| Screw Speed | Slow-Moderate | |

