

**HiFill® PA6/12 14082 GB30 BK**

Techmer Polymer Modifiers - Polyamide 612

**General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Bead, 30% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

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

**Physical**

	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.27		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955

**Mechanical**

	Nominal Value	Unit	Test Method
Tensile Modulus	460000	psi	ASTM D638
Tensile Strength (Yield)	5800	psi	ASTM D638
Tensile Strength (Break)	5500	psi	ASTM D638
Tensile Elongation (Break)	8.0	%	ASTM D638

**Impact**

	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.50	ft·lb/in	ASTM D256

**Processing Information**

**Injection**

	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	500 to 530	°F
Middle Temperature	510 to 540	°F
Front Temperature	520 to 550	°F
Nozzle Temperature	520 to 550	°F
Processing (Melt) Temp	500 to 550	°F
Mold Temperature	125 to 180	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Slow-Moderate	

