

## HiFill® PA6/12 L NAT

Techmer Polymer Modifiers - Polyamide 612

### General

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

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.06		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	355000	psi	ASTM D638
Tensile Strength (Yield)	9200	psi	ASTM D638
Tensile Elongation (Break)	23	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.76	ft·lb/in	ASTM D256

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	4.0	hr
Rear Temperature	450 to 525	°F
Middle Temperature	470 to 550	°F
Front Temperature	470 to 550	°F
Nozzle Temperature	470 to 550	°F
Processing (Melt) Temp	450 to 550	°F
Mold Temperature	125 to 175	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 100	psi
Screw Speed	Slow-Moderate	

