

## HiFill® J-4/35 NATL

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	1.19	g/cm <sup>3</sup>	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	20800	psi	ASTM D638
Tensile Stress (Break)	21700	psi	ISO 527-2
Tensile Elongation (Break)	2.4	%	ASTM D638
Tensile Strain (Break)	2.6	%	ISO 527-2
Flexural Modulus	1.28E+6	psi	ASTM D790
Flexural Modulus	1.36E+6	psi	ISO 178
Flexural Strength	29700	psi	ASTM D790
Flexural Stress	32700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.7	ft·lb/in	ASTM D256
Notched Izod Impact Strength (0.125 in)	5.1	ft·lb/in <sup>2</sup>	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	391	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	384	°F	ISO 75-2/A

### 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	

