

HiFill FR® PA6 FR IM 004

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Flame Retardant • Impact Modified
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.28		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.015	in/in	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	5700	psi	ASTM D638
Tensile Elongation (Break)	60	%	ASTM D638
Flexural Modulus	250000	psi	ASTM D790
Flexural Strength	8200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	3.0	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	97		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	145	°F	ASTM D648
CLTE - Flow	3.3E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	ASTM D257
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	530	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	450 to 495	°F
Middle Temperature	450 to 495	°F
Front Temperature	450 to 495	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm

