

HiFill® EXP149350-1

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber\Carbon Fiber, 30% Filler by Weight
Additive	• Heat Stabilizer • Lubricant
Features	• Heat Stabilized • Lubricated
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.33		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.48E+6	psi	ASTM D638
Tensile Strength (Yield)	24600	psi	ASTM D638
Tensile Elongation (Break, 73°F)	3.3	%	ASTM D638
Flexural Modulus	1.31E+6	psi	ASTM D790
Flexural Strength	27900	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	1.2	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	398	°F	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+3 to 1.0E+5	ohms	ASTM D257
Volume Resistivity	1.0E+3 to 1.0E+5	ohms·cm	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.12	%
Rear Temperature	460 to 510	°F
Middle Temperature	460 to 510	°F
Front Temperature	460 to 530	°F
Nozzle Temperature	460 to 550	°F
Processing (Melt) Temp	480 to 570	°F
Mold Temperature	130 to 200	°F
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi

Injection Notes

Screw Speed: Medium
 Recommendations for Molding and Tool Conditions: Well vented
 Moisture Content, as received: Product is packaged at 0.2% or less.
 Recommended Max Moisture: 0.12% down to 0.08%

