

**HiFill FR® PA6 FR IM GY205**

 Techmer Polymer Modifiers - *Polyamide 6*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant      • Impact Modifier
Features	• Flame Retardant      • Impact Modified
Appearance	• Grey
Processing Method	• Injection Molding

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

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.28		ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/2.16 kg)	3.0	g/10 min	ASTM D1238
Moisture (302°F)	0.096	%	
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	384000	psi	ASTM D638
Tensile Strength (Yield)	8500	psi	ASTM D638
Tensile Strength (Break)	6200	psi	ASTM D638
Tensile Elongation (Break)	42	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	1.2	ft·lb/in	ASTM D256
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating			UL 94
0.06 in	V-0		
0.12 in	V-0		

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	470 to 500	°F
Middle Temperature	480 to 510	°F
Front Temperature	490 to 520	°F
Nozzle Temperature	500 to 530	°F
Processing (Melt) Temp	480 to 525	°F
Mold Temperature	100 to 200	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

