

**HiFill FR® J-71/20/VO/ND BK2791**

 Techmer Polymer Modifiers - *Polyamide 6*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Black</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

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

Physical	Nominal Value	Unit	Test Method
Density	1.48	g/cm <sup>3</sup>	
Moisture (302°F)	0.080	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	15600	psi	ASTM D638
Tensile Stress (Yield)	8300	psi	ISO 527-2
Tensile Elongation (Break)	2.0	%	ASTM D638
Tensile Strain (Break)	2.0	%	ISO 527-2
Flexural Modulus	1.04E+6	psi	ASTM D790
Flexural Strength	23000	psi	ASTM D790
Flexural Stress	11600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
0.125 in	1.2	ft·lb/in	ASTM D256
0.125 in	0.86	ft·lb/in	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	278	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	284	°F	ISO 75-2/A
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 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	

