

**HiFill FR® PA6 GF33 FR HS L BL**

 Techmer Polymer Modifiers - *Polyamide 6*
**General Information**
**General**

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>
Filler / Reinforcement	<ul style="list-style-type: none"> <li>Glass Fiber, 33% Filler by Weight</li> </ul>
Additive	<ul style="list-style-type: none"> <li>Flame Retardant               <ul style="list-style-type: none"> <li>Heat Stabilizer</li> </ul> </li> </ul>
Features	<ul style="list-style-type: none"> <li>Flame Retardant               <ul style="list-style-type: none"> <li>Heat Stabilized</li> </ul> </li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Blue</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

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

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.63		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	1.80E+6	psi	ASTM D638
Tensile Strength (Yield)	22000	psi	ASTM D638
Tensile Strength (Break)	22000	psi	ASTM D638
Tensile Elongation (Break)	1.9	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	1.5	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 4.0	hr
Rear Temperature	430 to 470	°F
Middle Temperature	440 to 480	°F
Front Temperature	450 to 490	°F
Nozzle Temperature	460 to 500	°F
Processing (Melt) Temp	440 to 500	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

