

**HiFill FR® PA6 GF33 FR HS L WT393**

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

Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Additive	• Flame Retardant	• Heat Stabilizer	• Lubricant
Features	• Flame Retardant	• Heat Stabilized	• Lubricated
Appearance	• White		
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	1.60		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	1.72E+6	psi	ASTM D638
Tensile Strength (Yield)	22700	psi	ASTM D638
Tensile Strength (Break)	22600	psi	ASTM D638
Tensile Elongation (Break)	2.8	%	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 (0.12 in)	V-0		UL 94

**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

