

HiFill FR® PA6 GF25 FR IM

 Techmer Polymer Modifiers - *Polyamide 6*
General Information

General		
Material Status	• Commercial: Active	
Availability	• North America	
Filler / Reinforcement	• Glass Fiber	
Additive	• Flame Retardant	• Impact Modifier
Features	• Flame Retardant	• Impact Modified
UL File Number	• E157318	
Appearance	• Colors Available	
Forms	• Pellets	
Processing Method	• Injection Molding	

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.53		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.75	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	17000	psi	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Flexural Modulus	800000	psi	ASTM D790
Flexural Strength (Yield)	23000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.5	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	400	°F	ASTM D648
CLTE - Flow	1.8E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	ASTM D257
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	400	V/mil	ASTM D149
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 4.0	hr
Rear Temperature	450 to 495	°F
Middle Temperature	450 to 495	°F
Front Temperature	450 to 495	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm

