

HiFill FR® PA6 GF33 FR HS L RD

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber, 33% Filler by Weight
Additive	<ul style="list-style-type: none"> Flame Retardant <ul style="list-style-type: none"> Heat Stabilizer
Features	<ul style="list-style-type: none"> Flame Retardant <ul style="list-style-type: none"> Heat Stabilized
Appearance	<ul style="list-style-type: none"> Red
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.62		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
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
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.5	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		V-0	
0.12 in		V-0	

Processing Information

Injection	Nominal Value	Unit
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	

