

**HiFill® PA6 FR GF10 IM RAL1011**

 Techmer Polymer Modifiers - *Polyamide 6*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Additive	• Heat Stabilizer      • Impact Modifier
Features	• Heat Stabilized      • Impact Modified
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	1.18		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	435000	psi	ISO 527-1
Tensile Stress (Yield)	7720	psi	ISO 527-2
Tensile Strain (Yield)	3.2	%	ISO 527-2
Tensile Strain (Break)	5.4	%	ISO 527-2
Flexural Modulus	307000	psi	ISO 178
Flexural Stress	10700	psi	ISO 178
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	1.6	ft·lb/in	ISO 180
Notched Izod Impact Strength (0.125 in)	4.9	ft·lb/in <sup>2</sup>	ISO 180
Unnotched Izod Impact	7.9	ft·lb/in	ISO 180
Unnotched Izod Impact Strength	20	ft·lb/in <sup>2</sup>	ISO 180
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.030 in)	V-2		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	

