

HiFill® PA6 FR GF10 IM BK94431 - C

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Additive	• Flame Retardant • Impact Modifier
Features	• Flame Retardant • Impact Modified
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.17		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	392000	psi	ISO 527-1
Tensile Stress (Yield)	7630	psi	ISO 527-2
Tensile Strain (Yield)	4.1	%	ISO 527-2
Tensile Strain (Break)	7.1	%	ISO 527-2
Flexural Modulus	287000	psi	ISO 178
Flexural Stress	10100	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
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 ²	ISO 180
Unnotched Izod Impact	8.6	ft·lb/in	ISO 180
Unnotched Izod Impact Strength	22	ft·lb/in ²	ISO 180
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.030 in)	V-2		UL 94

Processing Information

Injection	Nominal Value	Unit
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	

