

HiFill® PA6 FR GF10 IM BK94431 - A

 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, 10% Filler by Weight
Additive	<ul style="list-style-type: none"> Impact Modifier
Features	<ul style="list-style-type: none"> Impact Modified
Appearance	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	435000	psi	ISO 527-1
Tensile Stress (Yield)	6990	psi	ISO 527-2
Tensile Strain (Yield)	3.4	%	ISO 527-2
Tensile Strain (Break)	16	%	ISO 527-2
Flexural Modulus	363000	psi	ISO 178
Flexural Stress	10400	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.2	ft·lb/in	ISO 180
Notched Izod Impact Strength (0.125 in)	3.8	ft·lb/in ²	ISO 180
Unnotched Izod Impact	7.6	ft·lb/in	ISO 180
Unnotched Izod Impact Strength	19	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	

