

HiFill® PA6 FR GF10 IM BK94431

 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	1.18		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3400	psi	ASTM D638
Tensile Strength (Yield)	67.0	psi	ASTM D638
Tensile Elongation (Yield)	6.5	%	ASTM D638
Tensile Elongation (Break)	3.8	%	ASTM D638
Flexural Modulus	2800	psi	ASTM D790
Flexural Strength	98.0	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	1.4	ft·lb/in	ASTM D256
Unnotched Izod Impact	9.2	ft·lb/in	ASTM D256
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	

