

**HiFill® PA6 GF20 LE GY88595**

 Techmer Polymer Modifiers - *Polyamide 6*
**General Information**
**General**

|                        |  |
|------------------------|--|
| Material Status        | <ul style="list-style-type: none"> <li>Commercial: Active</li> </ul> |
| Availability           | <ul style="list-style-type: none"> <li>North America</li> </ul>      |
| Filler / Reinforcement | <ul style="list-style-type: none"> <li>Glass Fiber</li> </ul>        |
| Appearance             | <ul style="list-style-type: none"> <li>Colors Available</li> </ul>   |
| Forms                  | <ul style="list-style-type: none"> <li>Pellets</li> </ul>            |
| Processing Method      | <ul style="list-style-type: none"> <li>Injection Molding</li> </ul>  |

**Properties <sup>1</sup>**

|   | Nominal Value | Unit     | Test Method |
|---|---------------|----------|-------------|
| <b>Physical</b>   |               |          |             |
| Density / Specific Gravity                              | 1.27          |          | ASTM D792   |
| Water Absorption (24 hr)                                | 1.1           | %        | ASTM D570   |
| <b>Mechanical</b>                                       |               |          |             |
| Tensile Modulus   | 893000        | psi      | ASTM D638   |
| Tensile Strength (Yield)                                | 14800         | psi      | ASTM D638   |
| Tensile Elongation (Break)                              | 4.7           | %        | ASTM D638   |
| Flexural Modulus  | 860000        | psi      | ASTM D790   |
| Flexural Strength                                       | 24800         | psi      | ASTM D790   |
| <b>Impact</b>   |               |          |             |
| Notched Izod Impact (73°F, 0.125 in)                    | 0.52          | ft·lb/in | ASTM D256   |
| <b>Thermal</b>  |               |          |             |
| Deflection Temperature Under Load (264 psi, Unannealed) | 365           | °F       | ASTM D648   |
| <b>Electrical</b>                                       |               |          |             |
| Volume Resistivity                                      | 1.0E+15       | ohms·cm  | ASTM D257   |

**Processing Information**

|                        | Nominal Value | Unit |
|------------------------|---------------|------|
| <b>Injection</b>       |               |      |
| Drying Temperature     | 180           | °F   |
| Drying Time            | 4.0           | hr   |
| Rear Temperature       | 500 to 580    | °F   |
| Middle Temperature     | 500 to 580    | °F   |
| Front Temperature      | 500 to 580    | °F   |
| Processing (Melt) Temp | 470 to 520    | °F   |
| Mold Temperature       | 150 to 200    | °F   |
| Back Pressure          | 0.00 to 50.0  | psi  |
| Screw Speed            | 30 to 60      | rpm  |

