

**HiFill® PA6 GF15 IM RA BK93293**

 Techmer Polymer Modifiers - *Polyamide 6*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Black
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
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	660000	psi	ASTM D638
Tensile Strength (Yield)	12300	psi	ASTM D638
Tensile Strength (Break)	11800	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	2.5	ft·lb/in	ASTM D256

**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	460 to 490	°F
Middle Temperature	470 to 500	°F
Front Temperature	480 to 510	°F
Nozzle Temperature	490 to 520	°F
Processing (Melt) Temp	470 to 525	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.
