

HiFill® PA6 GB40 L

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Bead, 40% Filler by Weight
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.43		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	750000	psi	ASTM D638
Tensile Strength (Yield)	6500	psi	ASTM D638
Tensile Elongation (Break)	15	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.70	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	480 to 550	°F
Middle Temperature	480 to 550	°F
Front Temperature	480 to 550	°F
Nozzle Temperature	480 to 550	°F
Processing (Melt) Temp	480 to 550	°F
Mold Temperature	105 to 175	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

Notes
¹ Typical properties: these are not to be construed as specifications.
