

**HiFill® PA6 GF20 IM LE GY88594**

 Techmer Polymer Modifiers - *Polyamide 6*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Features	• Impact Modified
Appearance	• Colors Available      • Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.20		ASTM D792
Water Absorption (24 hr)	1.1	%	ASTM D570
<b>Mechanical</b>			
Tensile Modulus	763000	psi	ASTM D638
Tensile Strength (Yield)	11800	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	655000	psi	ASTM D790
Flexural Strength	24800	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F, 0.125 in)	2.5	ft·lb/in	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	340	°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

