HiFill® PA6 GF20 SL1 RM GN113 A

Techmer Polymer Modifiers - *Polyamide 6*

General Information

Product Description	
1741102	
General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.28		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.4	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.00E+6	psi	ASTM D638
Tensile Strength (Yield)	15600	psi	ASTM D638
Tensile Strength (Break)	15000	psi	ASTM D638
Tensile Elongation (Break)	2.8	%	ASTM D638
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	0.56	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	115		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
CLTE - Flow	1.1E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	400	V/mil	ASTM D149

Processing Information

Injection	**Nominal Value**	**Unit**
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

Notes

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