

HiFill® PA6 GF25 IM HS L BK

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.27		ASTM D792
Molding Shrinkage - Flow (0.125 in)	1.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical			
Tensile Strength	18000	psi	ASTM D638
Tensile Elongation (Yield)	4.5	%	ASTM D638
Flexural Modulus	950000	psi	ASTM D790
Flexural Strength (Yield)	25000	psi	ASTM D790
Impact			
Notched Izod Impact (0.125 in)	3.8	ft·lb/in	ASTM D256
Hardness			
Rockwell Hardness (R-Scale)	112		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	415	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	400	°F	ASTM D648
CLTE - Flow	7.0E-6	in/in/°F	ASTM D696
Electrical			
Volume Resistivity	5.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	400	V/mil	ASTM D149

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	510 to 530	°F
Middle Temperature	530 to 550	°F
Front Temperature	520 to 540	°F
Nozzle Temperature	520 to 540	°F
Processing (Melt) Temp	530 to 550	°F
Mold Temperature	175 to 220	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi

Injection Notes

Screw Speed: Medium

Recommendations for Molding and Tool Conditions: Well vented mold

