

**HiFill® PA6 GF33 IM HS L GN612647**

 Techmer Polymer Modifiers - *Polyamide 6*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Heat Stabilizer • Impact Modifier • Lubricant
Features	• Heat Stabilized • Impact Modified • Lubricated
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	1.38		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	1.21E+6	psi	ASTM D638
Tensile Strength (Yield)	8800	psi	ASTM D638
Tensile Strength (Break)	8100	psi	ASTM D638
Tensile Elongation (Break)	1.7	%	ASTM D638
Flexural Modulus	992000	psi	ASTM D790
Flexural Strength	12300	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	3.0	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	470 to 500	°F
Middle Temperature	480 to 510	°F
Front Temperature	490 to 520	°F
Nozzle Temperature	500 to 530	°F
Processing (Melt) Temp	480 to 525	°F
Mold Temperature	100 to 200	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

