HiFill® PA6 GF30 L

Techmer Polymer Modifiers - *Polyamide 6*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Additive	• Lubricant
Features	• Lubricated
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	• 1.35 • 1.37		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	• 0.85 • 1.3	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	• 23500 • 25500	psi	ASTM D638
Tensile Elongation (Break)	• 2.4 • 3.0	%	ASTM D638
Flexural Modulus	• 150000 • 1.30E+6	psi	ASTM D790
Flexural Strength	• 31000 • 40000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	2.0	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	21	ft·lb/in	ASTM D4812
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness			ASTM D785
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R-Scale	118		
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	• 420 • 425	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648
CLTE - Flow	• 8.0E-6 • 9.0E-6	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))	450	V/mil	ASTM D149
Additional Information	**Nominal Value**	**Unit**	**Test Method**
TPCI #	7223102		

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.