HiFill® PA6 GF35 HS L BK

Techmer Polymer Modifiers - *Polyamide 6*

General Information

General		
Material Status	• Commercial: Active	
Availability	• North America	
Filler / Reinforcement	• Glass Fiber	
Additive	• Heat Stabilizer	• Lubricant
Features	• Heat Stabilized	• Lubricated
Appearance	• Colors Available	
Forms	• Pellets	
Processing Method	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.5E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	28000	psi	ASTM D638
Tensile Elongation (Yield)	3.5	%	ASTM D638
Flexural Modulus	1.35E+6	psi	ASTM D790
Flexural Strength (Yield)	34000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (0.125 in)	3.1	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	25	ft·lb/in	ASTM D4812
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	425	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	420	°F	ASTM D648
Melting Temperature	424	°F	
CLTE - Flow	1.7E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	3.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	480	V/mil	ASTM D149
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	HB		UL 94

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