

HiFill® PA6 GF33 BL512473

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Appearance	• Blue
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value Unit	Test Method
Density / Specific Gravity	1.41	ASTM D792
Mechanical	Nominal Value Unit	Test Method
Tensile Modulus	1.60E+6 psi	ASTM D638
Tensile Strength (Yield)	25000 psi	ASTM D638
Tensile Elongation (Break)	3.8 %	ASTM D638
Impact	Nominal Value Unit	Test Method
Notched Izod Impact (0.125 in)	2.6 ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value Unit
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

