

HiFill® PA6 GF33 IM HS L BL517620

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Heat Stabilizer • Impact Modifier
Features	• Heat Stabilized • Impact Modified
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.33		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	987000	psi	ASTM D638
Tensile Strength (Yield)	7400	psi	ASTM D638
Tensile Strength (Break)	6400	psi	ASTM D638
Tensile Elongation (Break)	4.3	%	ASTM D638
Flexural Modulus	929000	psi	ASTM D790
Flexural Strength	11400	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.4	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	

