

HiFill® PA6 GF33 IM HS L Plum 740566

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	• Lubricant
Features	• Heat Stabilized	• Impact Modified	• Lubricated
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	1.11E+6	psi	ASTM D638
Tensile Strength (Yield)	8100	psi	ASTM D638
Tensile Strength (Break)	7000	psi	ASTM D638
Tensile Elongation (Break)	2.1	%	ASTM D638
Flexural Modulus	970000	psi	ASTM D790
Flexural Strength	11700	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.1	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	

