

HiFill® PA6 GF33 UG HS BK

 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 • Lubricant
Features	• General Purpose • Heat Stabilized • Lubricated
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.38		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.1	%	ASTM D570
Mechanical			
Tensile Strength (Yield)	24500	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.30E+6	psi	ASTM D790
Flexural Strength	40000	psi	ASTM D790
Impact			
Notched Izod Impact (0.125 in)	2.0	ft-lb/in	ASTM D256
Hardness			
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	420	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648
Melting Temperature	428	°F	
CLTE - Flow	2.1E-5	in/in/°F	ASTM D696
Additional Information			
TPCI #	8943102		

Processing Information

	Nominal Value	Unit
Injection		
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

