

HiFill® PA6 GF33 IM L BK123

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.20E+6	psi	ASTM D638
Tensile Strength (Yield)	16000	psi	ASTM D638
Tensile Strength (Break)	16000	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	3.0	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	460 to 500	°F
Middle Temperature	470 to 510	°F
Front Temperature	480 to 520	°F
Nozzle Temperature	490 to 530	°F
Processing (Melt) Temp	470 to 525	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

