

**HiFill® PA6 GF/B30 IM L BK**

 Techmer Polymer Modifiers - *Polyamide 6*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Bead\Glass Fiber, 30% Filler by Weight
Additive	• Impact Modifier
Features	• Lubricated
Appearance	• Black • Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.31		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.017	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	71000	psi	ASTM D638
Tensile Strength (Yield)	9300	psi	ASTM D638
Tensile Strength (Break)	9000	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (73°F, 0.125 in)	1.3	ft-lb/in	ASTM D256
Notched Izod Impact (Area)	2.00	ft-lb/in <sup>2</sup>	ASTM D256
<b>Hardness</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Rockwell Hardness (R-Scale)	122		ASTM D785
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
CLTE - Flow	1.1E-5	in/in/°F	ASTM D696
<b>Electrical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.06 in)	HB		UL 94

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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

