

HiFill® PA6 GF5 IM LE GY88585

Techmer Polymer Modifiers - *Polyamide 6*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 5.0% Filler by Weight
Additive	• Impact Modifier
Features	• Lubricated
Appearance	• Colors Available • Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.10		ASTM D792
Water Absorption (24 hr)	1.5	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	407000	psi	ASTM D638
Tensile Strength (Yield)	8900	psi	ASTM D638
Tensile Elongation (Break)	8.7	%	ASTM D638
Flexural Modulus	391000	psi	ASTM D790
Flexural Strength	13500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.8	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	141	°F	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257

Processing Information

Injection	Nominal Value	Unit
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

