HiFill® PA6 GF60 HF

Techmer Polymer Modifiers - *Polyamide 6*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 60% Filler by Weight
Features	• High Flow
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.12		ASTM D792
Molding Shrinkage - Flow (0.125 in)	1.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.12	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	13000	psi	ASTM D638
Tensile Elongation (Break)	5.5	%	ASTM D638
Flexural Modulus	600000	psi	ASTM D790
Flexural Strength	18000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	2.0	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	15	ft·lb/in	ASTM D4812
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	390	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	318	°F	ASTM D648
CLTE - Flow	1.6E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+12	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	450	V/mil	ASTM D149

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