

HiFill® PA6 GF50 HS L

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 50% Filler by Weight
Additive	• Heat Stabilizer
Features	• Heat Stabilized
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.58		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.40E+6	psi	ASTM D638
Tensile Strength (Yield)	28000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.8	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	450 to 490	°F
Middle Temperature	460 to 500	°F
Front Temperature	465 to 505	°F
Nozzle Temperature	470 to 510	°F
Processing (Melt) Temp	450 to 510	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow	
Back Pressure	0.00 to 100	psi
Screw Speed	Slow-Moderate	

Notes
¹ Typical properties: these are not to be construed as specifications.
