

HiFill® PA6 RA IM HS NAT

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
Product Description

 PNM115224
 Impact Modified
 Heat Stabilizer

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.07		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.018	in/in	ASTM D955
Water Absorption (24 hr)	1.1	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	5400	psi	ASTM D638
Flexural Modulus	89000	psi	ASTM D790
Flexural Strength	4100	psi	ASTM D790
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	165	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	< 0.018	%
Rear Temperature	450 to 480	°F
Middle Temperature	460 to 490	°F
Front Temperature	480 to 510	°F
Nozzle Temperature	480 to 510	°F
Processing (Melt) Temp	470 to 520	°F
Mold Temperature	140 to 190	°F
Back Pressure	20.0 to 60.0	psi

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