HiFill® PA6 HS L

Techmer Polymer Modifiers - *Polyamide 6*

General Information

General		
Material Status	• Commercial: Active	
Availability	• North America	
Additive	• Heat Stabilizer	• Lubricant
Features	• Heat Stabilized	• Lubricated
Appearance	• Colors Available	
Forms	• Pellets	
Processing Method	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.13		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.012	in/in	ASTM D955
Water Absorption (24 hr)	1.6	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	11500	psi	ASTM D638
Tensile Elongation (Break)	70	%	ASTM D638
Flexural Modulus	410000	psi	ASTM D790
Flexural Strength	15700	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	1.1	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	119		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	352	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	149	°F	ASTM D648
CLTE - Flow	4.6E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+13	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	460	V/mil	ASTM D149
Additional Information	**Nominal Value**	**Unit**	**Test Method**
TPCI #	7190102		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	4.0	hr
Rear Temperature	480 to 540	°F
Middle Temperature	480 to 540	°F
Front Temperature	480 to 540	°F