HiFill® PA6 IM 835 HS L

Techmer Polymer Modifiers - *Polyamide 6*

General Information

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

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.04		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.016	in/in	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	6500	psi	ASTM D638
Tensile Elongation (Yield)	250	%	ASTM D638
Flexural Modulus	100000	psi	ASTM D790
Flexural Strength	8500	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	No Break		ASTM D256
Unnotched Izod Impact (0.125 in)	No Break		ASTM D4812
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore D)	70		ASTM D2240
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	330	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	125	°F	ASTM D648
CLTE - Flow	1.3E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	2.0E+13	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	420	V/mil	ASTM D149

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	490 to 555	°F
Middle Temperature	490 to 555	°F
Front Temperature	490 to 555	°F
Processing (Melt) Temp	460 to 530	°F
Mold Temperature	150 to 180	°F
Back Pressure	50.0 to 100	psi
Screw Speed	30 to 60	rpm