

HiFill® PA6 IM 409 L MB

 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

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.10		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.016	in/in	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Mechanical			
Tensile Strength (Break)	9700	psi	ASTM D638
Tensile Elongation (Break)	50	%	ASTM D638
Flexural Modulus	320000	psi	ASTM D790
Flexural Strength	11500	psi	ASTM D790
Impact			
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	2.5	ft·lb/in	
73°F, 0.125 in	3.0	ft·lb/in	
Unnotched Izod Impact (0.125 in)	No Break		ASTM D4812
Hardness			
Rockwell Hardness (R-Scale)	110		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	310	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	140	°F	ASTM D648
CLTE - Flow	4.6E-5	in/in/°F	ASTM D696
Electrical			
Volume Resistivity	2.0E+13	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	420	V/mil	ASTM D149
Flammability			
Flame Rating	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
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

