HiFill® PA6 LG/LCF30 2000 12mm

Techmer Polymer Modifiers - *Polyamide 6*

General Information

General			
Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Long Carbon Fiber	• Long Glass Fiber	
Features	• Heat Stabilized	• Lubricated	
Appearance	• Colors Available • Colors Available	• Colors Available • Colors Available	• Natural Color
Forms	• Pellets [1]		
Processing Method	• Injection Molding		

Properties [2]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.32		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3 to 5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.35	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	36000	psi	ASTM D638
Tensile Elongation (Break)	2.0 to 3.0	%	ASTM D638
Flexural Modulus	1.90E+6	psi	ASTM D790
Flexural Strength	48000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	4.5	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	16	ft·lb/in	ASTM D4812
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	405	°F	ASTM D648
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	500	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 510	°F
Middle Temperature	500 to 520	°F
Front Temperature	480 to 500	°F
Nozzle Temperature	540 to 560	°F
Processing (Melt) Temp	500 to 580	°F
Mold Temperature	130 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 75.0	psi

Injection Notes

Screw Speed: Slow
Recommendations for Molding and Tool Conditions: Well vented

Moisture Content, as received: Product is packaged at 0.2% or less.
Recomended Max Moisture: 0.12% down to 0.08%