

HiFill® PA6 L N LE GY365

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Lubricant • Nucleating Agent
Features	• Low Extractables • Lubricated • Nucleated
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.13		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	509000	psi	ASTM D638
Tensile Strength (Yield)	12200	psi	ASTM D638
Tensile Strength (Break)	8470	psi	ASTM D638
Tensile Elongation (Break)	15	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.80	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	500 to 580	°F
Middle Temperature	500 to 580	°F
Front Temperature	500 to 580	°F
Nozzle Temperature	500 to 580	°F
Processing (Melt) Temp	460 to 535	°F
Mold Temperature	160 to 180	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi

