

HiFill® PA6 L N MB MT045 EL-A

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Lubricant • Nucleating Agent
Features	• Lubricated • Nucleated
Appearance	• Black
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)	0.010 to 0.015	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	470000	psi	ASTM D638
Tensile Strength (Yield)	11000	psi	ASTM D638
Tensile Strength (Break)	9500	psi	ASTM D638
Tensile Elongation (Break)	10	%	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 3.0	hr
Rear Temperature	470 to 500	°F
Middle Temperature	480 to 510	°F
Front Temperature	490 to 520	°F
Nozzle Temperature	500 to 530	°F
Processing (Melt) Temp	480 to 525	°F
Mold Temperature	100 to 200	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

