

HiFill® PA6 NAT

 Techmer Polymer Modifiers - *Polyamide 6*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Appearance	<ul style="list-style-type: none"> Natural Color
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.13		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	400000	psi	ASTM D638
Tensile Strength (Yield)	9500	psi	ASTM D638
Tensile Strength (Break)	9000	psi	ASTM D638
Tensile Elongation (Break)	35	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.70	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	450 to 490	°F
Middle Temperature	460 to 500	°F
Front Temperature	470 to 510	°F
Nozzle Temperature	480 to 520	°F
Processing (Melt) Temp	460 to 520	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

Notes

¹ Typical properties: these are not to be construed as specifications.

