

HiFill® TPX-IONOMER-02055

 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
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.36		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.31E+6	psi	ASTM D638
Tensile Strength (Yield)	16800	psi	ASTM D638
Tensile Strength (Break)	16800	psi	ASTM D638
Tensile Elongation (Break)	4.3	%	ASTM D638
Flexural Modulus	1.25E+6	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.3	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	385	°F	ASTM D648

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

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