

HiFill® 1-70020 BR

Techmer Polymer Modifiers - *Polyamide 66*

General Information

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Material Status	• Commercial: Active
Availability	• North America
Appearance	• Brown
Processing Method	• Injection Molding

Properties ¹

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	22500	psi	ASTM D638
Tensile Elongation (Break)	2.7	%	ASTM D638
Flexural Modulus	1.47E+6	psi	ASTM D790
Flexural Strength	34900	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.1	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	510 to 540	°F
Middle Temperature	520 to 550	°F
Front Temperature	530 to 560	°F
Nozzle Temperature	540 to 570	°F
Processing (Melt) Temp	515 to 565	°F
Mold Temperature	125 to 200	°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.

