

HiFill® 1-90392 BK

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Glass Fiber		
Additive	• Heat Stabilizer	• Impact Modifier	• UV Stabilizer
Features	• Heat Stabilized	• Impact Modified	• UV Stabilized
Appearance	• Black		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.16		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	610000	psi	ASTM D638
Tensile Strength (Yield)	12000	psi	ASTM D638
Tensile Strength (Break)	11500	psi	ASTM D638
Tensile Elongation (Break)	3.8	%	ASTM D638
Flexural Modulus	5.60E+6	psi	ASTM D790
Flexural Strength	19000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.2	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	490 to 520	°F
Middle Temperature	500 to 530	°F
Front Temperature	510 to 540	°F
Nozzle Temperature	520 to 550	°F
Processing (Melt) Temp	495 to 555	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

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