

HiFill® 1-70019 BR

 Techmer Polymer Modifiers - *Polyamide 66*
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"> Brown
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	10100	psi	ASTM D638
Tensile Elongation (Break)	7.1	%	ASTM D638
Flexural Modulus	546000	psi	ASTM D790
Flexural Strength	17300	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.1	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.

