

**HiFill FR® PA6/6 GF13 FR HS L PL054**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant • Heat Stabilizer • Lubricant
Features	• Flame Retardant • Heat Stabilized • Lubricated
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.40		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	800000	psi	ASTM D638
Tensile Strength (Yield)	13000	psi	ASTM D638
Tensile Strength (Break)	13000	psi	ASTM D638
Tensile Elongation (Break)	2.2	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.50	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	4.0	hr
Rear Temperature	520 to 540	°F
Middle Temperature	520 to 550	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 540	°F
Processing (Melt) Temp	535 to 570	°F
Mold Temperature	150 to 180	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

