

HiFill® 3-PA6 MIN BLACK 094273

 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
Filler / Reinforcement	<ul style="list-style-type: none"> Mineral
Appearance	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.40		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	10500	psi	ASTM D638
Tensile Elongation (Break)	1.9	%	ASTM D638
Flexural Modulus	1.00E+6	psi	ASTM D790
Flexural Strength	17500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.60	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	450 to 490	°F
Middle Temperature	460 to 500	°F
Front Temperature	470 to 505	°F
Nozzle Temperature	480 to 510	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

