

HiFill FR® PA6/6 GF25 FR NAT003

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Additive	• Heat Stabilizer • Lubricant
Features	• Flame Retardant • Heat Stabilized • Lubricated
UL File Number	• E157318
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.51		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Mechanical			
Tensile Strength (Yield)	19900	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	1.05E+6	psi	ASTM D790
Flexural Strength	27200	psi	ASTM D790
Impact			
Notched Izod Impact	2.1	ft-lb/in	ASTM D256
Hardness			
Rockwell Hardness (R-Scale)	120		ASTM D785
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	465	°F	ASTM D648
CLTE - Flow	2.0E-5	in/in/°F	ASTM D696
Electrical			
Surface Resistivity	1.0E+13	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	440	V/mil	ASTM D149
Flammability			
Flame Rating			UL 94
0.06 in, natural, black & colors	V-0		
0.12 in, natural, black & colors	5VA		
Additional Information			
TPCI #	8230101		

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	180	°F
Drying Time	> 6.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	490 to 530	°F
Front Temperature	490 to 530	°F
Processing (Melt) Temp	480 to 520	°F
Mold Temperature	150 to 200	°F



Back Pressure	50.0 to 100 psi
Screw Speed	30 to 60 rpm

Notes

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

