

HiFill FR® PA6/6 GF25 FR IM BK94027

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Additive	• Flame Retardant • Impact Modifier
Features	• Flame Retardant • Impact Modified
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.36		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical			
Tensile Modulus	850000	psi	ASTM D638
Tensile Strength (Yield)	13500	psi	ASTM D638
Tensile Strength (Break)	13000	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	970000	psi	ASTM D790
Flexural Strength	19000	psi	ASTM D790
Impact			
Notched Izod Impact (0.125 in)	2.6	ft·lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	402	°F	ASTM D648
Flammability			
Flame Rating (0.12 in)	V-0		UL 94

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	500 to 540	°F
Front Temperature	510 to 550	°F
Nozzle Temperature	520 to 555	°F
Processing (Melt) Temp	500 to 555	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

