

**HiFill® PA6/6 CF20 IM L BK**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 20% Filler by Weight
Additive	• Impact Modifier      • Lubricant
Features	• Conductive              • Lubricated
Appearance	• Black                      • Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.19		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.85	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.90E+6	psi	ASTM D638
Tensile Strength (Yield)	22000	psi	ASTM D638
Tensile Strength (Break)	22000	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Strength	40000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	2.2	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2 to 1.0E+6	ohms	ASTM D257
Volume Resistivity	1.0E+2 to 1.0E+6	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 580	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	175 to 220	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi

**Injection Notes**

Screw Speed: Slow  
 Recommendations for Molding and Tool Conditions: Well vented mold  
 Moisture Content, as received: Product is packaged at 0.2% or less.

