

HiFill® PA SS24 Blue 3-PS1

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

| | |
|-------------------|----------------------|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Appearance | • Blue |
| Processing Method | • Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|--------------------------------|---------------|-----------------------|-------------|
| Density / Specific Gravity | 1.65 | | ASTM D792 |
| Moisture (311°F) | 0.050 | % | |
| Mechanical | Nominal Value | Unit | Test Method |
| Flexural Modulus | 2.41E+6 | psi | ISO 178 |
| Flexural Stress | 46900 | psi | ISO 178 |
| Impact | Nominal Value | Unit | Test Method |
| Unnotched Izod Impact Strength | 29 | ft·lb/in ² | ISO 180 |

Processing Information

| Injection | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature | 180 | °F |
| Drying Time | 2.0 to 3.0 | hr |
| Rear Temperature | 510 to 540 | °F |
| Middle Temperature | 520 to 550 | °F |
| Front Temperature | 530 to 560 | °F |
| Nozzle Temperature | 540 to 570 | °F |
| Processing (Melt) Temp | 515 to 565 | °F |
| Mold Temperature | 125 to 200 | °F |
| Injection Rate | Slow | |
| Back Pressure | 25.0 to 75.0 | psi |
| Screw Speed | Slow-Moderate | |

