

**HiFill® PA6/6 408 IM L LE**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Additive	<ul style="list-style-type: none"> <li>Impact Modifier</li> </ul>
Features	<ul style="list-style-type: none"> <li>Impact Modified</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Natural Color</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.08		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	250000	psi	ASTM D638
Tensile Strength (Yield)	7500	psi	ASTM D638
Tensile Strength (Break)	6500	psi	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	10	ft-lb/in	ASTM D256
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (66 psi, Unannealed)	205	°F	ASTM D648

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	500 to 530	°F
Middle Temperature	510 to 540	°F
Front Temperature	520 to 550	°F
Nozzle Temperature	525 to 555	°F
Processing (Melt) Temp	500 to 555	°F
Mold Temperature	125 to 225	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.
