

**HiFill FR® PA6/6 GF25 FR-N IM NAT A3**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
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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	• Natural Color
Processing Method	• Injection Molding

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

Flammability	Nominal Value	Test Method
Flame Rating		UL 94
0.030 in	V-0	
0.06 in	V-0	
0.12 in	V-0	

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	4.0	hr
Rear Temperature	520 to 540	°F
Middle Temperature	520 to 540	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 540	°F
Processing (Melt) Temp	535 to 570	°F
Mold Temperature	150 to 180	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

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