

HiFill FR® PA6/6 GF25 FR-N IM BK92479

 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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.36		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	950000	psi	ASTM D638
Tensile Strength (Yield)	12000	psi	ASTM D638
Tensile Elongation (Break)	4.5	%	ASTM D638
Flexural Modulus	700000	psi	ASTM D790
Flexural Strength	21000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.5	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	430	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		V-1	
0.12 in		V-0	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	500 to 550	°F
Middle Temperature	510 to 560	°F
Front Temperature	520 to 570	°F
Nozzle Temperature	530 to 580	°F
Processing (Melt) Temp	525 to 575	°F
Mold Temperature	100 to 200	°F
Injection Rate	Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

