

HiFill FR® PA6/6 GF25 FR-N IM

 Techmer Polymer Modifiers - *Polyamide 66*
General Information

General			
Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight		
Additive	• Impact Modifier		
Features	• Flame Retardant	• High Impact Resistance	
UL File Number	• E157318		
Appearance	• Colors Available	• Natural Color	• Red
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.31		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	14400	psi	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Flexural Modulus	800000	psi	ASTM D790
Flexural Strength	19000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F	2.2	ft·lb/in	
73°F	4.2	ft·lb/in	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	85		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	445	°F	ASTM D648
CLTE - Flow	2.0E-5	in/in/°F	ASTM D696
RTI Elec	248	°F	UL 746B
RTI Imp	248	°F	UL 746B
RTI Str	248	°F	UL 746B
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	ASTM D257
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	520	V/mil	ASTM D149
Comparative Tracking Index (CTI)	550	V	UL 746A
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-0		
0.08 in	5VA		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	> 6.0	hr
Rear Temperature	490 to 530	°F



Middle Temperature	490 to 530 °F
Front Temperature	490 to 530 °F
Processing (Melt) Temp	480 to 520 °F
Mold Temperature	150 to 200 °F
Back Pressure	50.0 to 100 psi
Screw Speed	30 to 60 rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

