

**HiFill FR® PA6/6 GF25 FR NAT005**

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	• Heat Stabilizer • Lubricant
Features	• Flame Retardant • High Flow • Heat Stabilized • Lubricated
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.56		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength (Yield)	23400	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	1.20E+6	psi	ASTM D790
Flexural Strength	30000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact	1.9	ft-lb/in	ASTM D256
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	120		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	480	°F	ASTM D648
CLTE - Flow	2.0E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Surface Resistivity	1.0E+13	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms-cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	440	V/mil	ASTM D149
<b>Flammability</b>			
Flame Rating (0.06 in)	V-0		UL 94

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
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

