

**HiFill® NY-1/MS/5 NAT**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
**General**

Material Status	• Commercial: Active
Availability	• North America
Additive	• Molybdenum Disulfide Lubricant
Features	• Lubricated
Appearance	• Natural Color
Processing Method	• Injection Molding

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

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.17		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	520000	psi	ASTM D638
Tensile Strength (Yield)	12000	psi	ASTM D638
Tensile Strength (Break)	12000	psi	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
Flexural Modulus	450000	psi	ASTM D790
Flexural Strength	15000	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	0.70	ft-lb/in	ASTM D256

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	510 to 540	°F
Middle Temperature	520 to 550	°F
Front Temperature	530 to 560	°F
Nozzle Temperature	535 to 565	°F
Processing (Melt) Temp	520 to 565	°F
Mold Temperature	150 to 225	°F
Injection Rate	Moderate-Fast	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

