

HiFill FR® PA6/6 T40 GF24 IM FR BK95028

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 10% 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	1.37		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.10E+6	psi	ASTM D638
Tensile Strength (Yield)	13500	psi	ASTM D638
Tensile Strength (Break)	13500	psi	ASTM D638
Tensile Elongation (Break)	2.8	%	ASTM D638
Flexural Modulus	1.00E+6	psi	ASTM D790
Flexural Strength	21000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.4	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	490 to 530	°F
Middle Temperature	500 to 540	°F
Front Temperature	510 to 550	°F
Nozzle Temperature	520 to 555	°F
Processing (Melt) Temp	500 to 555	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

