

**HiFill® PA H19 Red 1-PS1**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Appearance	• Red
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.60		ASTM D792
Moisture (311°F)	0.060	%	
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	2.19E+6	psi	ISO 178
Flexural Stress	43800	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (Area)	27.1	ft·lb/in <sup>2</sup>	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
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	540 to 570	°F
Processing (Melt) Temp	515 to 565	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

