

HiFill® PA6/6 GF14 IM4 HS L BKN

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 14% Filler by Weight
Additive	• Heat Stabilizer • Impact Modifier • Lubricant
Features	• Heat Stabilized • Impact Modified • Lubricated
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.16		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.013	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus	360000	psi	ASTM D790
Flexural Strength	16000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	3.8	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	475	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	426	°F	ASTM D648
CLTE - Flow	3.4E-5	in/in/°F	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 580	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	175 to 220	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi

Injection Notes

Screw Speed: Slow
 Recommendations for Molding and Tool Conditions: Well vented mold
 Moisture Content, as received: Product is packaged at 0.2% or less.

