

HiFill® PA6/6 GB40 HS BK

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

| | |
|------------------------|------------------------------------|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Filler / Reinforcement | • Glass Bead, 40% Filler by Weight |
| Additive | • Heat Stabilizer |
| Features | • Heat Stabilized |
| Appearance | • Black |
| Processing Method | • Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|-------------------------------------|----------------------|-------------|--------------------|
| Density / Specific Gravity | 1.45 | | ASTM D792 |
| Molding Shrinkage - Flow (0.125 in) | 0.015 to 0.018 | in/in | ASTM D955 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 730000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 7200 | psi | ASTM D638 |
| Tensile Strength (Break) | 7000 | psi | ASTM D638 |
| Tensile Elongation (Break) | 5.5 | % | ASTM D638 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 0.60 | ft·lb/in | ASTM D256 |

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 560 | °F |
| Processing (Melt) Temp | 500 to 565 | °F |
| Mold Temperature | 125 to 200 | °F |
| Injection Rate | Slow | |
| Back Pressure | 0.00 to 50.0 | psi |
| Screw Speed | Slow-Moderate | |

Notes
¹ Typical properties: these are not to be construed as specifications.
