

HiFill® PA6/6 GF14 IM HS L NAT

 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	• Natural Color		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.19		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	616000	psi	ASTM D638
Tensile Strength (Yield)	13500	psi	ASTM D638
Tensile Strength (Break)	13200	psi	ASTM D638
Tensile Elongation (Break)	5.7	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.6	ft·lb/in	ASTM D256

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	180	°F
Drying Time	4.0	hr
Rear Temperature	520 to 540	°F
Middle Temperature	520 to 540	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 540	°F
Processing (Melt) Temp	535 to 570	°F
Mold Temperature	150 to 180	°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.
