HiFill® PA6/6 GF13 IM2 HS L

Techmer Polymer Modifiers - *Polyamide 66*

General Information

General			
Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight		
Additive	• Heat Stabilizer	• Impact Modifier	• Lubricant
Features	• Heat Stabilized	• High Impact Resistance	• Lubricated
Appearance	• Colors Available		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.19		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.1	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	13300	psi	ASTM D638
Tensile Elongation (Break)	4.4	%	ASTM D638
Flexural Modulus	550000	psi	ASTM D790
Flexural Strength	18200	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	2.0	ft·lb/in	
73°F, 0.125 in	3.2	ft·lb/in	
Unnotched Izod Impact (0.125 in)	No Break		ASTM D4812
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	111		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	480	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	430	°F	ASTM D648
Melting Temperature	490	°F	
CLTE - Flow	3.0E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	490	V/mil	ASTM D149
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	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.

Notes

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