

**HiFill® PA6/6 GF30 HS L**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
**General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Additive	• Heat Stabilizer • Lubricant
Features	• Heat Stabilized • Lubricated
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.35		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.55	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength (Break)	27300	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	1.29E+6	psi	ASTM D790
Flexural Strength	38000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (73°F, 0.125 in)	2.2	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	18	ft·lb/in	ASTM D4812
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	121		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load (66 psi, Unannealed)	500	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	490	°F	ASTM D648
Melting Temperature	491	°F	
CLTE - Flow	1.8E-5	in/in/°F	ASTM D696
<b>Electrical</b>			
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	480	V/mil	ASTM D149
<b>Flammability</b>			
Flame Rating	HB		UL 94

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.12	%
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	540 to 560	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	130 to 200	°F
Injection Rate	Moderate-Fast	



---

Back Pressure

50.0 to 100 psi

---

**Injection Notes**

---

Screw Speed: Medium

Recommendations for Molding and Tool Conditions: Well vented

Moisture Content, as received: Product is packaged at 0.2% or less.

Recommended Max Moisture: 0.12% down to 0.08%

---

**Notes**

---

<sup>1</sup> Typical properties: these are not to be construed as specifications.

