

**HiFill® PA6/6 GF33 FR HS L**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Lubricant
Features	• Lubricated
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.38		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.55	%	ASTM D570
Water Absorption (Saturation)	5.1	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	27000	psi	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Flexural Modulus	1.30E+6	psi	ASTM D790
Flexural Strength	32000	psi	ASTM D790
Shear Strength	12100	psi	ASTM D732
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	2.2	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	505	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	499	°F	ASTM D648
Melting Temperature	499	°F	
CLTE - Flow	1.8E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	500	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94
Additional Information	Nominal Value	Unit	Test Method
TPCI #	8263101		

**Processing Information**

Injection	Nominal Value	Unit
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.

