

HiFill® PA6/6 GF4 IM L LE

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

4306101

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier • Lubricant
Features	• High Impact Resistance • Low Extractables • Lubricated
Agency Ratings	• FDA
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.14		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.012	in/in	ASTM D955
Water Absorption (24 hr)	1.3	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	393000	psi	ASTM D638
Tensile Strength (Yield)	8340	psi	ASTM D638
Tensile Strength (Break)	7720	psi	ASTM D638
Tensile Elongation (Break)	16	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	3.1	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	No Break		ASTM D4812
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	420	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	160	°F	ASTM D648
CLTE - Flow	4.4E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	2.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	440	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	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.

