

HiFill® PA6/6 GF4 IM L LE NAT

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 4.0% Filler by Weight
Additive	• Impact Modifier
Features	• Impact Modified
Agency Ratings	• FDA
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.10		ASTM D792
Molding Shrinkage - Flow (0.125 in)	8.0E-3 to 0.010	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	400000	psi	ASTM D638
Tensile Strength (Yield)	8500	psi	ASTM D638
Tensile Strength (Break)	8500	psi	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	12500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	3.5	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	510 to 540	°F
Middle Temperature	520 to 550	°F
Front Temperature	530 to 560	°F
Nozzle Temperature	535 to 565	°F
Processing (Melt) Temp	520 to 560	°F
Mold Temperature	175 to 250	°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.
