

HiFill® PA6/6 GF30 ML5 HS BK

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 • Molybdenum Disulfide Lubricant
Features	• Heat Stabilized • Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3 to 8.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.00E+6	psi	ASTM D638
Tensile Strength (Yield)	23000	psi	ASTM D638
Tensile Strength (Break)	23000	psi	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.2	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.

