

**HiFill® PA6/6 G/CF30 L BK**

 Techmer Polymer Modifiers - *Polyamide 66*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber/Carbon Fiber, 30% Filler by Weight
Additive	• Lubricant
Features	• Conductive • Lubricated
Appearance	• Black
Processing Method	• Injection Molding

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

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.34		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 6.0E-3	in/in	ASTM D955
<b>Mechanical</b>			
Tensile Modulus	2.10E+6	psi	ASTM D638
Tensile Strength (Yield)	28000	psi	ASTM D638
Tensile Strength (Break)	27500	psi	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
<b>Impact</b>			
Notched Izod Impact (0.125 in)	1.3	ft·lb/in	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	482	°F	ASTM D648
<b>Electrical</b>			
Surface Resistivity	1.0E+2 to 1.0E+8	ohms	ASTM D257

**Processing Information**

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	490 to 520	°F
Middle Temperature	500 to 530	°F
Front Temperature	510 to 540	°F
Nozzle Temperature	520 to 550	°F
Processing (Melt) Temp	495 to 555	°F
Mold Temperature	125 to 200	°F
Injection Rate		Slow
Back Pressure	0.00 to 50.0	psi
Screw Speed		Slow-Moderate

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