

**HiFill® PA6/6 IM L N**

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

<b>General</b>			
Material Status	• Commercial: Active		
Availability	• North America		
Additive	• Impact Modifier	• Lubricant	• Nucleating Agent
Features	• Impact Modified	• Lubricated	• Nucleated
UL File Number	• E157318		
Appearance	• Colors Available		
Forms	• Pellets		
Processing Method	• Injection Molding		

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

	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
<b>Physical</b>			
Density / Specific Gravity	1.08		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.013	in/in	ASTM D955
Water Absorption (24 hr)	1.3	%	ASTM D570
<b>Mechanical</b>			
Tensile Strength	7000	psi	ASTM D638
Tensile Elongation (Yield)	48	%	ASTM D638
Flexural Modulus	260000	psi	ASTM D790
Flexural Strength (Yield)	8600	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	3.4	ft·lb/in	
73°F, 0.125 in	15	ft·lb/in	
Unnotched Izod Impact (0.125 in)	No Break		ASTM D4812
<b>Hardness</b>			
Rockwell Hardness (R-Scale)	110		ASTM D785
<b>Thermal</b>			
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
<b>Electrical</b>			
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	440	V/mil	ASTM D149
<b>Flammability</b>			
Flame Rating	HB		UL 94
<b>Additional Information</b>			
TPCI #	9170101		

**Processing Information**

	<b>Nominal Value</b>	<b>Unit</b>
<b>Injection</b>		
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	2.0 to 4.0	%
Rear Temperature	510 to 580	°F
Middle Temperature	510 to 580	°F
Front Temperature	510 to 580	°F
Processing (Melt) Temp	500 to 540	°F



Mold Temperature	150 to 200 °F
Back Pressure	50.0 to 100 psi
Screw Speed	30 to 60 rpm

#### Notes

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

