

**HiFill® PA6/6 IM L LE GY365**

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

|                   |   |
|-------------------|---|
| Material Status   | • Commercial: Active  |
| Availability      | • North America   |
| Additive          | • Impact Modifier      • Lubricant                          |
| Features          | • Impact Modified      • Low Extractables      • Lubricated |
| Processing Method | • Injection Molding   |

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

| <b>Physical</b>                | <b>Nominal Value</b> | <b>Unit</b> | <b>Test Method</b> |
|--------------------------------|----------------------|-------------|--------------------|
| Density / Specific Gravity     | 1.08                 |             | ASTM D792          |
| <b>Mechanical</b>              | <b>Nominal Value</b> | <b>Unit</b> | <b>Test Method</b> |
| Tensile Modulus                | 300000               | psi         | ASTM D638          |
| Tensile Strength (Yield)       | 7800                 | psi         | ASTM D638          |
| Tensile Strength (Break)       | 7000                 | psi         | ASTM D638          |
| Tensile Elongation (Break)     | 33                   | %           | ASTM D638          |
| <b>Impact</b>                  | <b>Nominal Value</b> | <b>Unit</b> | <b>Test Method</b> |
| Notched Izod Impact (0.125 in) | 15                   | ft·lb/in    | ASTM D256          |

**Processing Information**

| <b>Injection</b>       | <b>Nominal Value</b> | <b>Unit</b> |
|------------------------|----------------------|-------------|
| Drying Temperature     | 180                  | °F          |
| Drying Time            | 4.0                  | hr          |
| Rear Temperature       | 520 to 540           | °F          |
| Middle Temperature     | 520 to 550           | °F          |
| Front Temperature      | 530 to 550           | °F          |
| Nozzle Temperature     | 520 to 540           | °F          |
| Processing (Melt) Temp | 535 to 570           | °F          |
| Mold Temperature       | 150 to 180           | °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.

