

HiFill® PA6/6 GF/M35 HS BK

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

| | |
|------------------------|---|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Filler / Reinforcement | • Glass Fiber/Mineral, 35% Filler by Weight |
| Additive | • Heat Stabilizer • Lubricant |
| Features | • Heat Stabilized • Lubricated |
| Appearance | • Black |
| Forms | • Pellets |
| Processing Method | • Injection Molding |

Properties ¹

| | Nominal Value | Unit | Test Method |
|---|---------------|----------|-------------|
| Physical | | | |
| Density / Specific Gravity | 1.41 | | ASTM D792 |
| Molding Shrinkage - Flow (0.125 in) | 6.0E-3 | in/in | ASTM D955 |
| Water Absorption (24 hr) | 0.70 | % | ASTM D570 |
| Mechanical | | | |
| Tensile Strength (Break) | 16600 | psi | ASTM D638 |
| Tensile Elongation (Break) | 4.0 | % | ASTM D638 |
| Flexural Modulus | 1.00E+6 | psi | ASTM D790 |
| Flexural Strength | 23000 | psi | ASTM D790 |
| Impact | | | |
| Notched Izod Impact (73°F, 0.125 in) | 1.0 | ft·lb/in | ASTM D256 |
| Unnotched Izod Impact (0.125 in) | 10 | ft·lb/in | ASTM D4812 |
| Hardness | | | |
| Rockwell Hardness (R-Scale) | 122 | | ASTM D785 |
| Thermal | | | |
| Deflection Temperature Under Load (66 psi, Unannealed) | 488 | °F | ASTM D648 |
| Deflection Temperature Under Load (264 psi, Unannealed) | 395 | °F | ASTM D648 |
| CLTE - Flow | 1.0E-5 | in/in/°F | ASTM D696 |
| Electrical | | | |
| Volume Resistivity | 1.0E+13 | ohms·cm | ASTM D257 |
| Dielectric Strength (Method A (Short-Time)) | 400 | V/mil | ASTM D149 |

Processing Information

| | Nominal Value | Unit |
|------------------------|---------------|------|
| Injection | | |
| Drying Temperature | 180 | °F |
| Drying Time | 2.0 to 4.0 | hr |
| Suggested Max Moisture | 0.12 | % |
| Rear Temperature | 540 to 560 | °F |
| Middle Temperature | 550 to 570 | °F |
| Front Temperature | 530 to 550 | °F |
| Nozzle Temperature | 540 to 560 | °F |
| Processing (Melt) Temp | 540 to 580 | °F |
| Mold Temperature | 130 to 200 | °F |
| Injection Rate | Moderate-Fast | |
| Back Pressure | 50.0 to 100 | psi |

Injection Notes


Screw Speed: Medium

Recommendations for Molding and Tool Conditions: Well vented

Moisture Content, as received: Product is packaged at 0.2% or less.

Recommended Max Moisture: 0.12% down to 0.08%

Notes

¹ Typical properties: these are not to be construed as specifications.

