

HiFill® PA6/6 IM 04 LE GY135 HF

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier • Lubricant
Features	• High Impact Resistance • Low Extractables • Lubricated
Agency Ratings	• FDA
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.13		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.012	in/in	ASTM D955
Water Absorption (24 hr)	1.3	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	7810	psi	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus	255000	psi	ASTM D790
Flexural Strength	11500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	3.4	ft·lb/in	
73°F, 0.125 in	4.0	ft·lb/in	
Unnotched Izod Impact (0.125 in)	No Break		ASTM D4812
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Thermal	Nominal Value	Unit	Test Method
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
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	2.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	440	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 580	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	175 to 220	°F



Injection Rate	Slow-Moderate
Back Pressure	0.00 to 50.0 psi

Injection Notes

Screw Speed: Slow
Recommendations for Molding and Tool Conditions: Well vented mold
Moisture Content, as received: Product is packaged at 0.2% or less.

Notes

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

