

HiFill® PA6/6 IM X

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Heat Stabilizer • Impact Modifier • Lubricant
Features	• Heat Stabilized • Impact Modified • Lubricated
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.08		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.016	in/in	ASTM D955
Water Absorption (24 hr)	1.3	%	ASTM D570
Mechanical			
Tensile Strength	7500	psi	ASTM D638
Tensile Elongation (Yield)	48	%	ASTM D638
Flexural Modulus	250000	psi	ASTM D790
Flexural Strength (Yield)	11500	psi	ASTM D790
Impact			
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	3.4	ft·lb/in	
73°F, 0.125 in	16	ft·lb/in	
Unnotched Izod Impact (0.125 in)	No Break		ASTM D4812
Hardness			
Rockwell Hardness (R-Scale)	110		ASTM D785
Thermal			
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			
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	440	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	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

