

**HiFill® PA6/6 IM 6408 LE BL246**

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

General	
Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Impact Modified • Low Extractables
Appearance	• Blue
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.12		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	399000	psi	ASTM D638
Tensile Strength (Yield)	10100	psi	ASTM D638
Tensile Strength (Break)	8100	psi	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.7	ft·lb/in	ASTM D256

**Processing Information**

	Nominal Value	Unit
<b>Injection</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.

