HiFill® PA6/6 IM 408 L

Techmer Polymer Modifiers - *Polyamide 66*

General Information

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

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.09		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.015	in/in	ASTM D955
Water Absorption (24 hr)	1.2	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	8600	psi	ASTM D638
Tensile Elongation (Break)	80	%	ASTM D638
Flexural Modulus	275000	psi	ASTM D790
Flexural Strength (Yield)	12000	psi	ASTM D790
Flexural Strength (Break)	11600	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	1.0	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)	102		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	435	°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	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	440	V/mil	ASTM D149

Processing Information

Injection	Nominal Value	Unit
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