

HiFill® PA6/6 GF60 X

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

Conditioned 48 hrs, 50% RH

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 60% Filler by Weight
Additive	• Heat Stabilizer • Lubricant
Features	• Heat Stabilized • Lubricated
UL File Number	• E157318
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.70		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.35	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield	30000	psi	
Yield, 200°F	21000	psi	
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus			ASTM D790
--	2.80E+6	psi	
200°F	2.20E+6	psi	
Flexural Strength	48000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	3.9	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	No Break		ASTM D4812
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	495	°F	ASTM D648
CLTE - Flow	1.3E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+11	ohms	ASTM D257
Volume Resistivity	1.0E+9	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	500	V/mil	ASTM D149
Additional Information	Nominal Value	Unit	Test Method
TPCI #	7859101		

Processing Information

Injection	Nominal Value	Unit
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.

