

HiFill® PA6/6 GF60 L BK

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber, 60% Filler by Weight
Appearance	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.71		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.90E+6	psi	ASTM D638
Tensile Strength (Yield)	27000	psi	ASTM D638
Tensile Elongation (Break)	1.8	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.5	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	520 to 550	°F
Middle Temperature	525 to 555	°F
Front Temperature	530 to 560	°F
Nozzle Temperature	535 to 565	°F
Processing (Melt) Temp	525 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

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

