HiFill® PA6/6 GF8 IM3 BK

Techmer Polymer Modifiers - *Polyamide 66*

General Information

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

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.16		ASTM D792
Molding Shrinkage - Flow (0.125 in)	8.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	11200	psi	ASTM D638
Tensile Elongation (Yield)	4.0	%	ASTM D638
Flexural Modulus	400000	psi	ASTM D790
Flexural Strength (Yield)	15000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	2.2	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	111		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	485	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	428	°F	ASTM D648
CLTE - Flow	3.0E-5	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	490	V/mil	ASTM D149
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	540 to 560	°F
Middle Temperature	550 to 570	°F
Front Temperature	530 to 550	°F
Nozzle Temperature	520 to 580	°F
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	175 to 220	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi

Injection Notes

Screw Speed: Slow
Recommendations for Molding and Tool Conditions: Well vented mold
Moisture Content, as received: Product is packaged at 0.2% or less.

Notes

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