

HiFill® PA6/6 IM 408 L MB

 Techmer Polymer Modifiers - *Polyamide 66*
General Information
General

| | |
|-------------------|-------------------------------------|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Additive | • Impact Modifier • Lubricant |
| Features | • Impact Modified • Lubricated |
| Processing Method | • Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|--------------------------------|----------------------|-------------|--------------------|
| Density / Specific Gravity | 1.12 | | ASTM D792 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 436000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 10900 | psi | ASTM D638 |
| Tensile Strength (Break) | 9000 | psi | ASTM D638 |
| Tensile Elongation (Break) | 17 | % | ASTM D638 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.125 in) | 1.9 | ft·lb/in | ASTM D256 |

Processing Information

| Injection | Nominal Value | Unit |
|------------------------|----------------------|-------------|
| Drying Temperature | 180 | °F |
| Drying Time | 2.0 to 3.0 | hr |
| Rear Temperature | 510 to 540 | °F |
| Middle Temperature | 520 to 550 | °F |
| Front Temperature | 530 to 560 | °F |
| Nozzle Temperature | 540 to 570 | °F |
| Processing (Melt) Temp | 515 to 565 | °F |
| Mold Temperature | 125 to 200 | °F |
| Injection Rate | Slow | |
| Back Pressure | 25.0 to 75.0 | psi |
| Screw Speed | Slow-Moderate | |

Notes

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

