

**HiFill® PA6/6 IM L LE**

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

<b>General</b>	
Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Additive	<ul style="list-style-type: none"> <li>Impact Modifier</li> </ul>
Features	<ul style="list-style-type: none"> <li>Impact Modified</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.09		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	300000	psi	ASTM D638
Tensile Strength (Yield)	7800	psi	ASTM D638
Tensile Strength (Break)	6800	psi	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	11	ft·lb/in	ASTM D256

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
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	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

**Notes**

<sup>1</sup> Typical properties: these are not to be construed as specifications.

